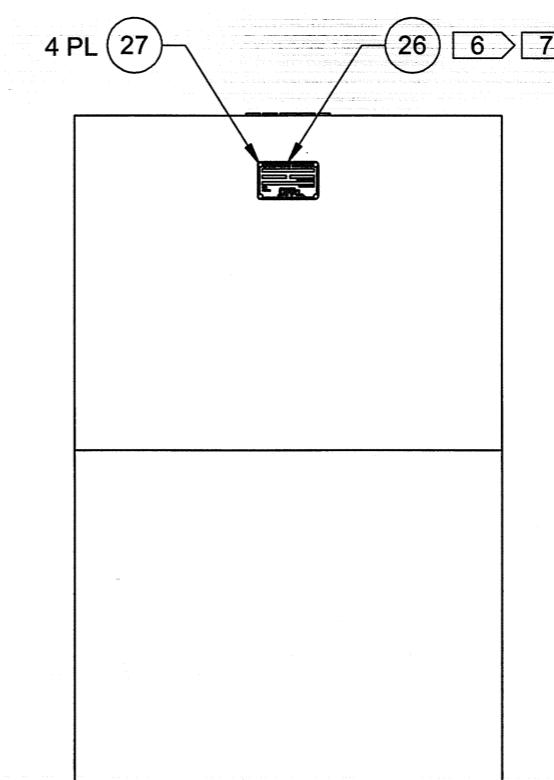
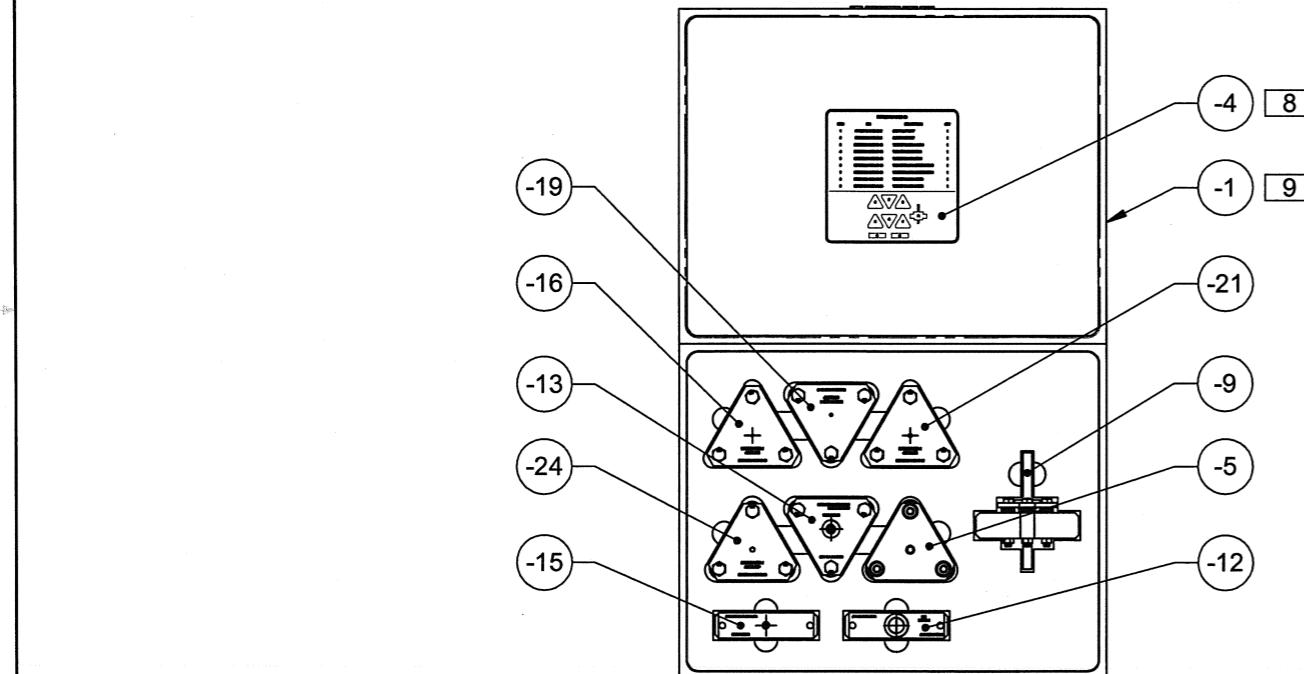


ITEM #	QTY	PART #	PART TITLE
-1	1	RBE332A94-3400-03-1	PACKAGING ASSEMBLY
-4	1	RBE332A94-3400-03-4	LOCATION PLACARD
-5	1	RBE332A94-3400-03-5	SIGHT SUPPORT
-9	1	RBE332A94-3400-03-9	SIGHT SUPPORT
-12	1	RBE332A94-3400-03-12	TARGET BLOCK 4 & 5
-13	1	RBE332A94-3400-03-13	TARGET MGB / IGB / TGB
-15	1	RBE332A94-3400-03-15	TARGET BLOCK 2 TO 6
-16	1	RBE332A94-3400-03-16	TARGET BLOCK 1 FABRICATION
-19	1	RBE332A94-3400-03-19	TARGET BLOCK 1 FABRICATION
-21	1	RBE332A94-3400-03-21	TARGET BLOCK 1 USER
-24	1	RBE332A94-3400-03-24	TARGET BLOCK 1 USER
26	1	RB41011	DART PLACARD
27	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

C



RBE332A94-3400-03 T/R DRIVE ALIGNMENT INSPECTION

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED

7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINUM POP RIVETS

8) HOT GLUE THE LOCATION PLACARD ONTO THE TOP FOAM

9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	i9-585	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB		
MFG. APPR.	DP		
APPROVED	VWP		
TOOL PART #		REV. A	
RBE332A94-3400-03		SHEET 1 OF 26	
TITLE		SCALE	
T/R DRIVE ALIGNMENT INSPECTION		NTS	
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBE332A94-3400-03-2	BOTTOM FOAM
-3	1	RBE332A94-3400-03-3	TOP FOAM
28	1	PELICAN #APP-iM2700-E	PELICAN iM2700

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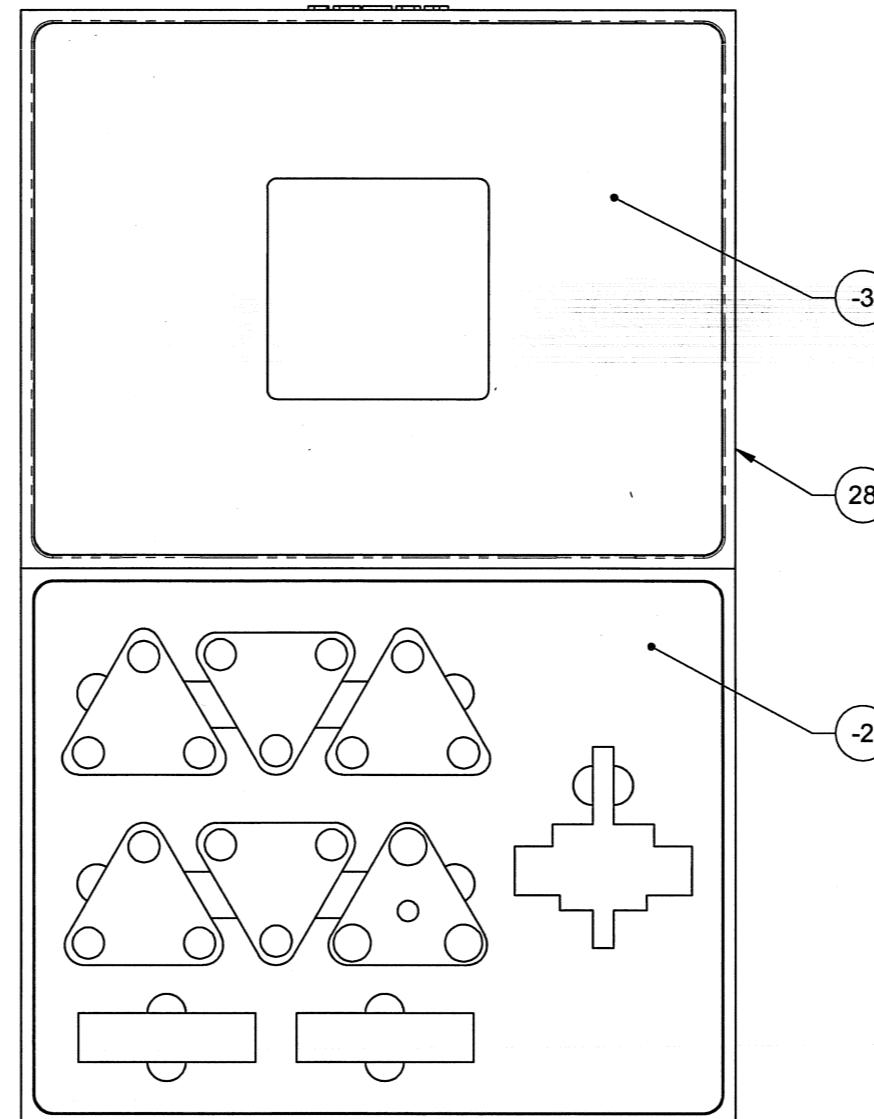
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RBE332A94-3400-03-1 PACKAGING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	Vf	REV. A
TITLE		SHEET 2 OF 26
T/R DRIVE ALIGNMENT INSPECTION		SCALE
		NTS
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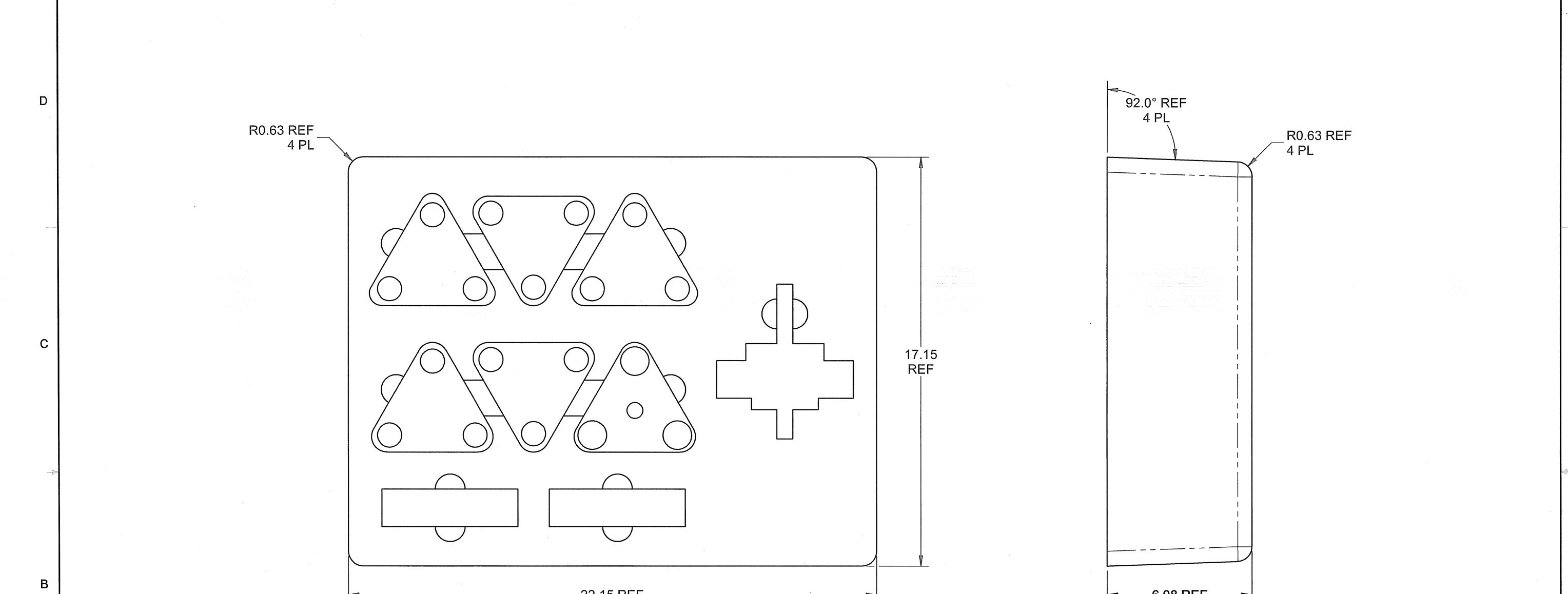
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RBE332A94-3400-03-2 BOTTOM FOAM

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NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220 REF
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE332A94-3400-03-2 REV. A.STEP

DESIGN DRAWN	KPT	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	
APPROVED	VJL	REV. A RBE332A94-3400-03	
		SHEET 3 OF 26	
		TITLE	
		T/R DRIVE ALIGNMENT INSPECTION	
		SCALE	NTS
DATE 2/14/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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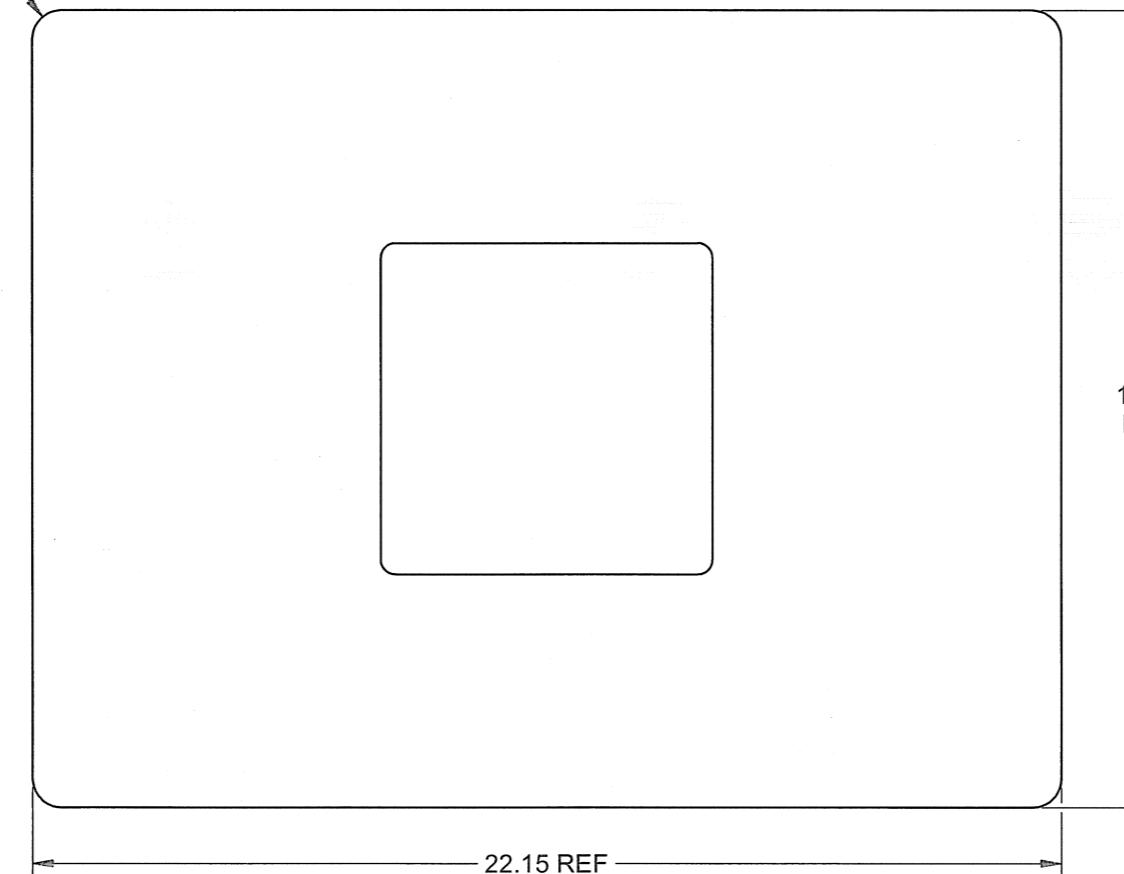
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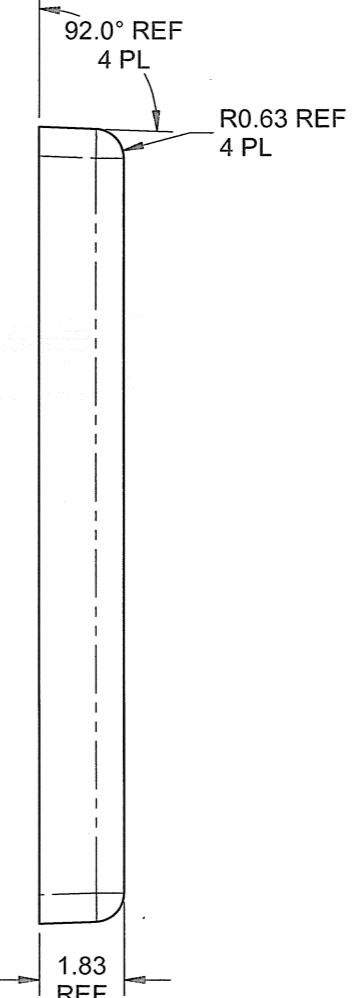
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R0.63 REF
4 PL17.15
REF

22.15 REF

1.83
REF**RBE332A94-3400-03-3 TOP FOAM**

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NOTES:

1) MATERIAL: BLACK ETHAFOAM 220 REF

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

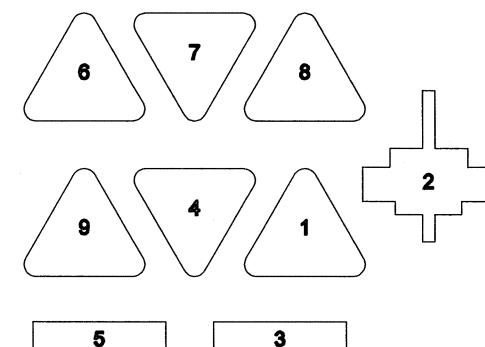
7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE332A94-3400-03-3 REV. A.STEP

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	WJ	REV. A TITLE SHEET 4 OF 26 T/R DRIVE ALIGNMENT INSPECTION SCALE NTS
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		DATE 2/14/2019

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RBE332A94-3400-03

ITEM	P/N	DESCRIPTION	QTY
1	RBE332A94-3400-03-5	SIGHT SUPPORT	1
2	RBE332A94-3400-03-9	SIGHT SUPPORT	1
3	RBE332A94-3400-03-12	TARGET BLOCK 4 AND 5	1
4	RBE332A94-3400-03-13	TARGET MGB/IGB/TGB	1
5	RBE332A94-3400-03-15	TARGET BLOCK 2 TO 6	1
6	RBE332A94-3400-03-16	TARGET BLOCK 1 FABRICATION	1
7	RBE332A94-3400-03-19	TARGET BLOCK 1 FABRICATION	1
8	RBE332A94-3400-03-21	TARGET BLOCK 1 USER	1
9	RBE332A94-3400-03-24	TARGET BLOCK 1 USER	1



7.00

7.00

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RBE332A94-3400-03-4 LOCATION PLACARD

NOTES:
1) MATERIAL: MULTI-CRAFT PLASTICS # LM922402 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

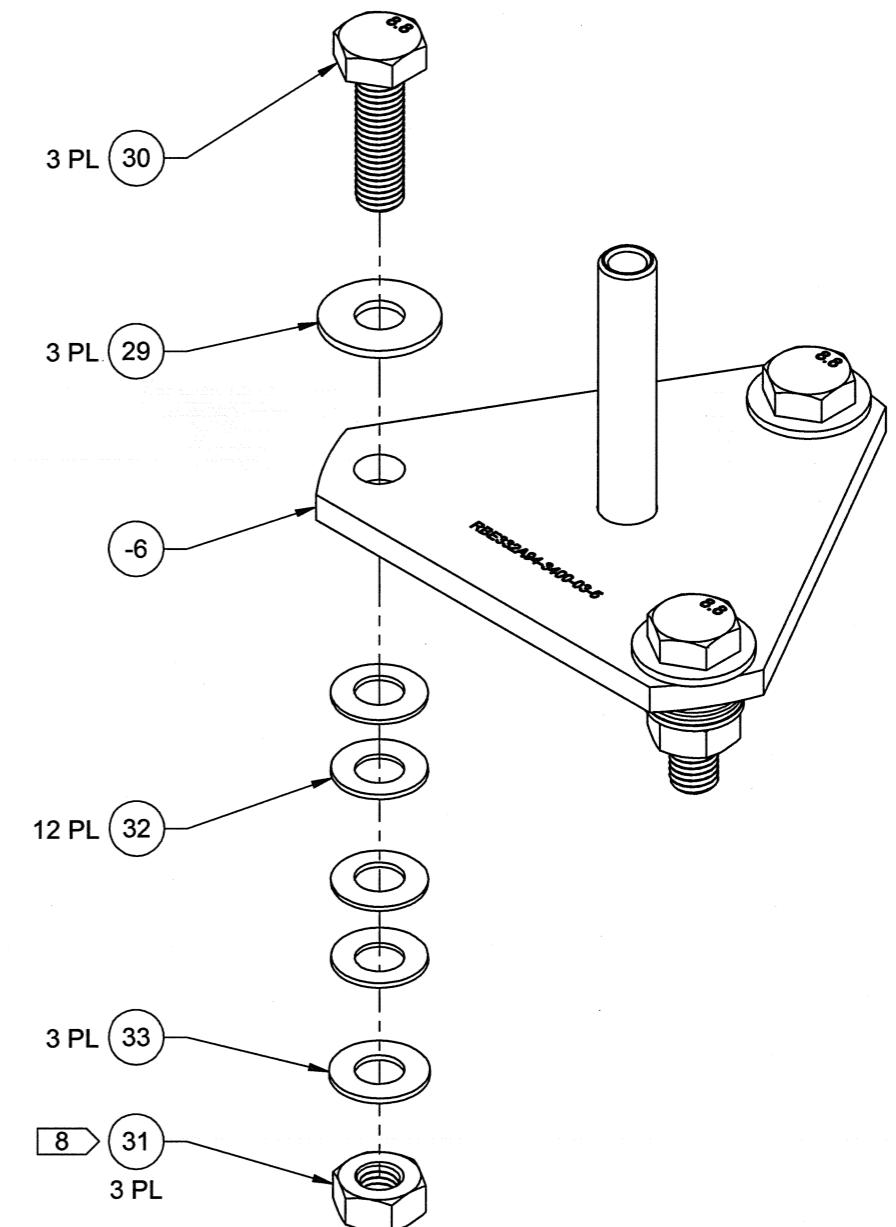
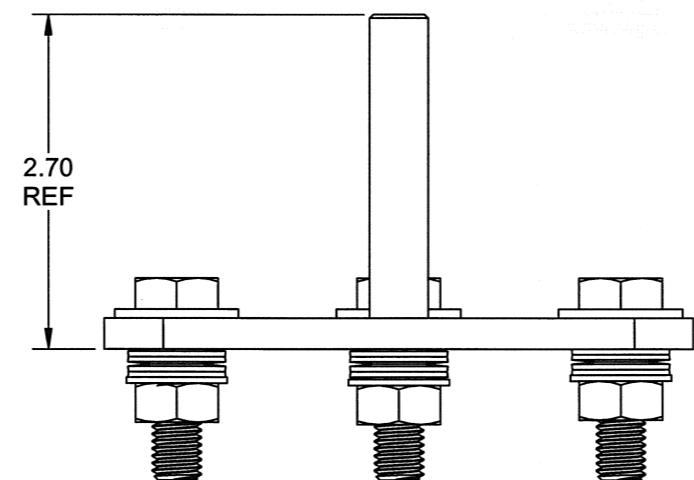
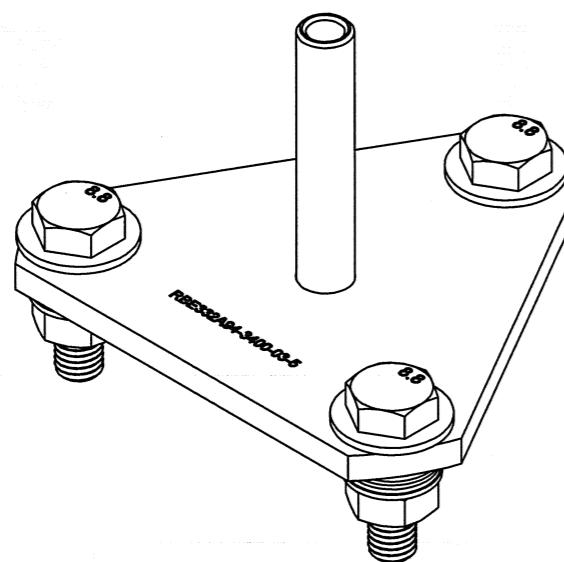
6) IDENTIFICATION: N/A

7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RBE332A94-3400-03-4 REV. A.DXF

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	REV. A	TOOL PART #
APPROVED	WT	RBE332A94-3400-03	SHEET 5 OF 26
TITLE		T/R DRIVE ALIGNMENT INSPECTION	
DATE 2/14/2019		SCALE NTS	COPYRIGHT © 2019 BY DART AEROSPACE LTD
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ITEM #	QTY	PART #	PART TITLE
-6	1	RBE332A94-3400-03-6	SIGHT SUPPORT WELDMENT
29	3	McMaster#91090A112 OR EQUIV.	ZINC PLATED STEEL WASHER 0.406" ID. X 1.000" OD. X 0.056"-0.071" THK.
30	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
31	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
32	12	McMaster#96445K251 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 10.2 mm ID. X 1.1 mm THK.
33	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.



RBE332A94-3400-03-5 SIGHT SUPPORT

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 31 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	RBE332A94-3400-03
APPROVED	WY	REV. A	SHEET 6 OF 26
TITLE T/R DRIVE ALIGNMENT INSPECTION		SCALE NTS	
DATE 2/14/2019			

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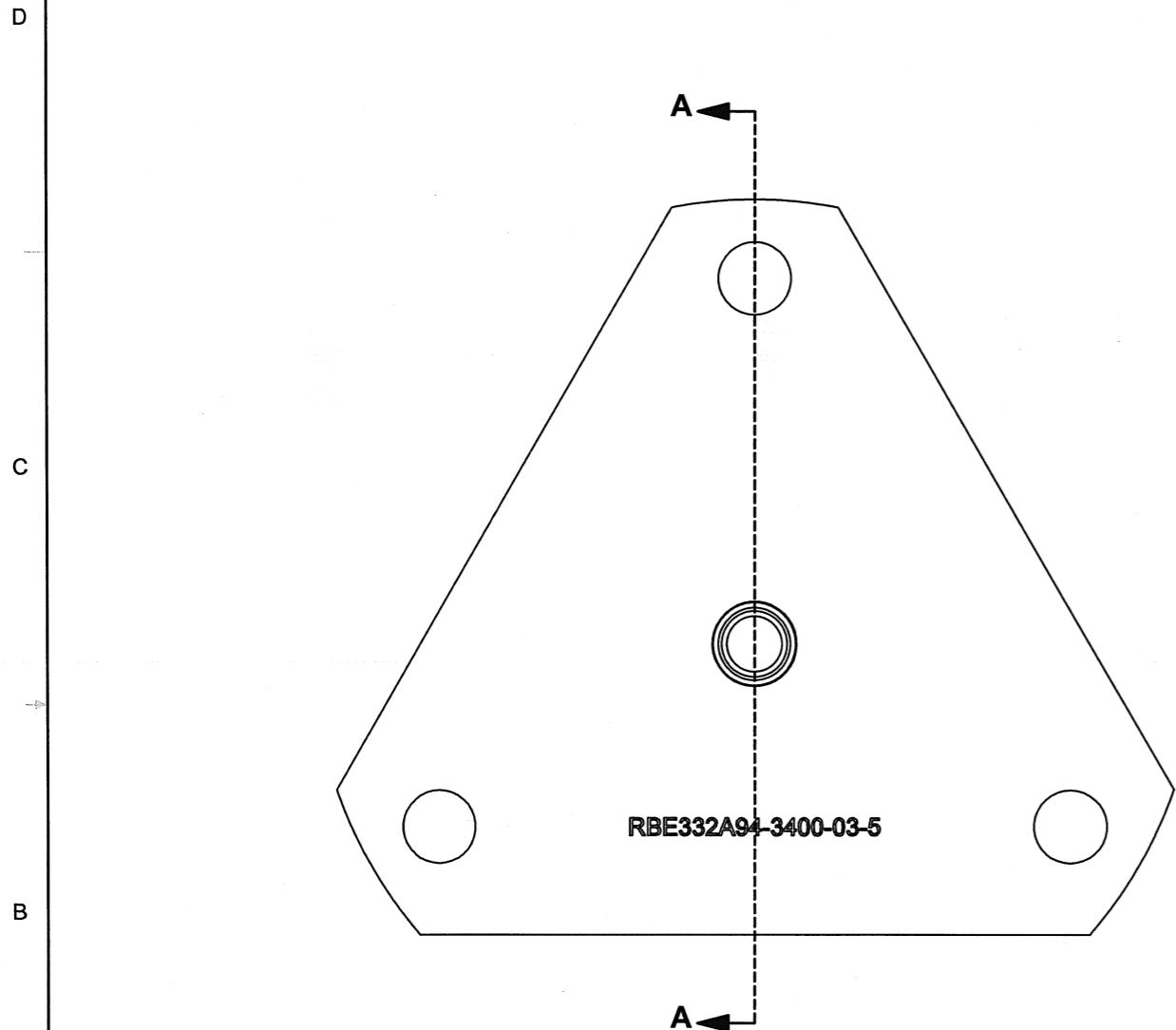
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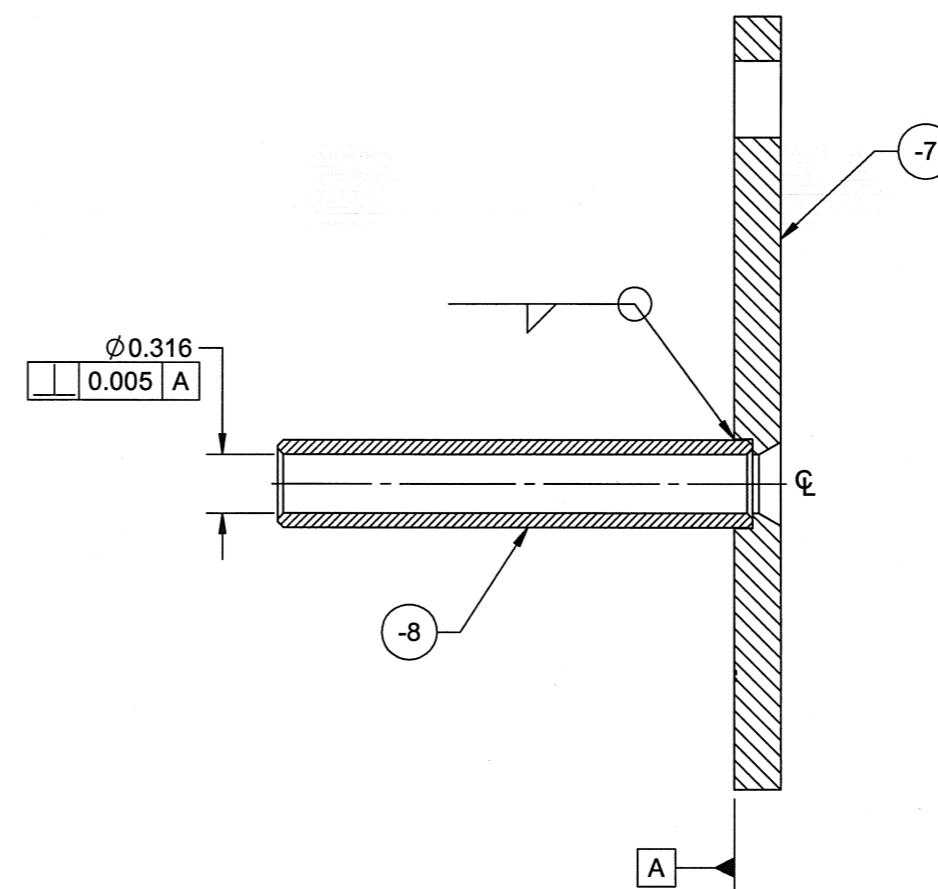
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ITEM #	QTY	PART #	PART TITLE
-7	1	RBE332A94-3400-03-7	BASE
-8	1	RBE332A94-3400-03-8	TUBE



RBE332A94-3400-03-6 SIGHT SUPPORT WELDMENT



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL WELD SPATTERS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 7 OF 26
APPROVED	VY	TITLE T/R DRIVE ALIGNMENT INSPECTION	
DATE 2/14/2019		SCALE	NTS
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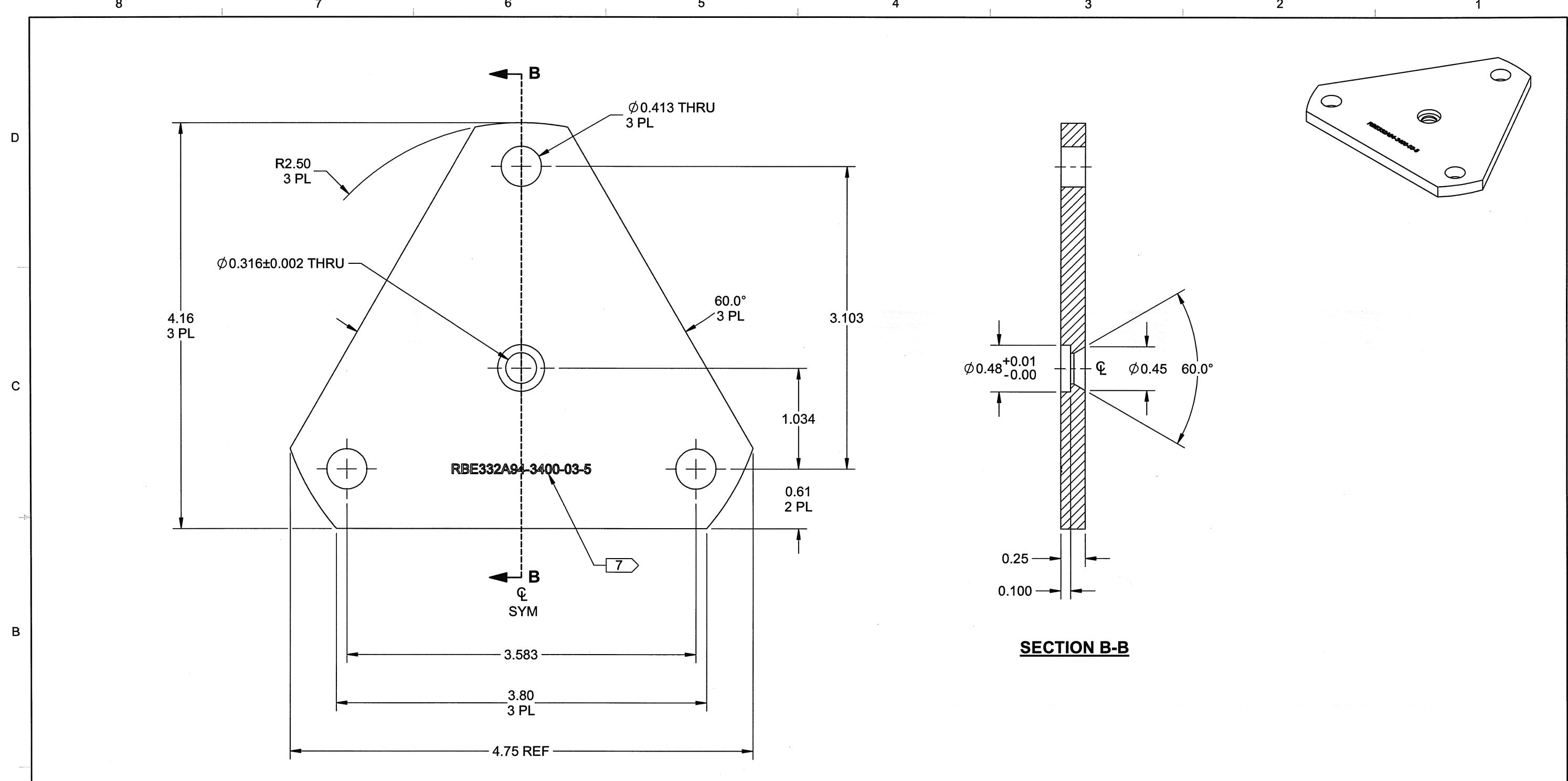
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RBE332A94-3400-03-7 BASE

NOTES

- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 8 OF 26
APPROVED	VH	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
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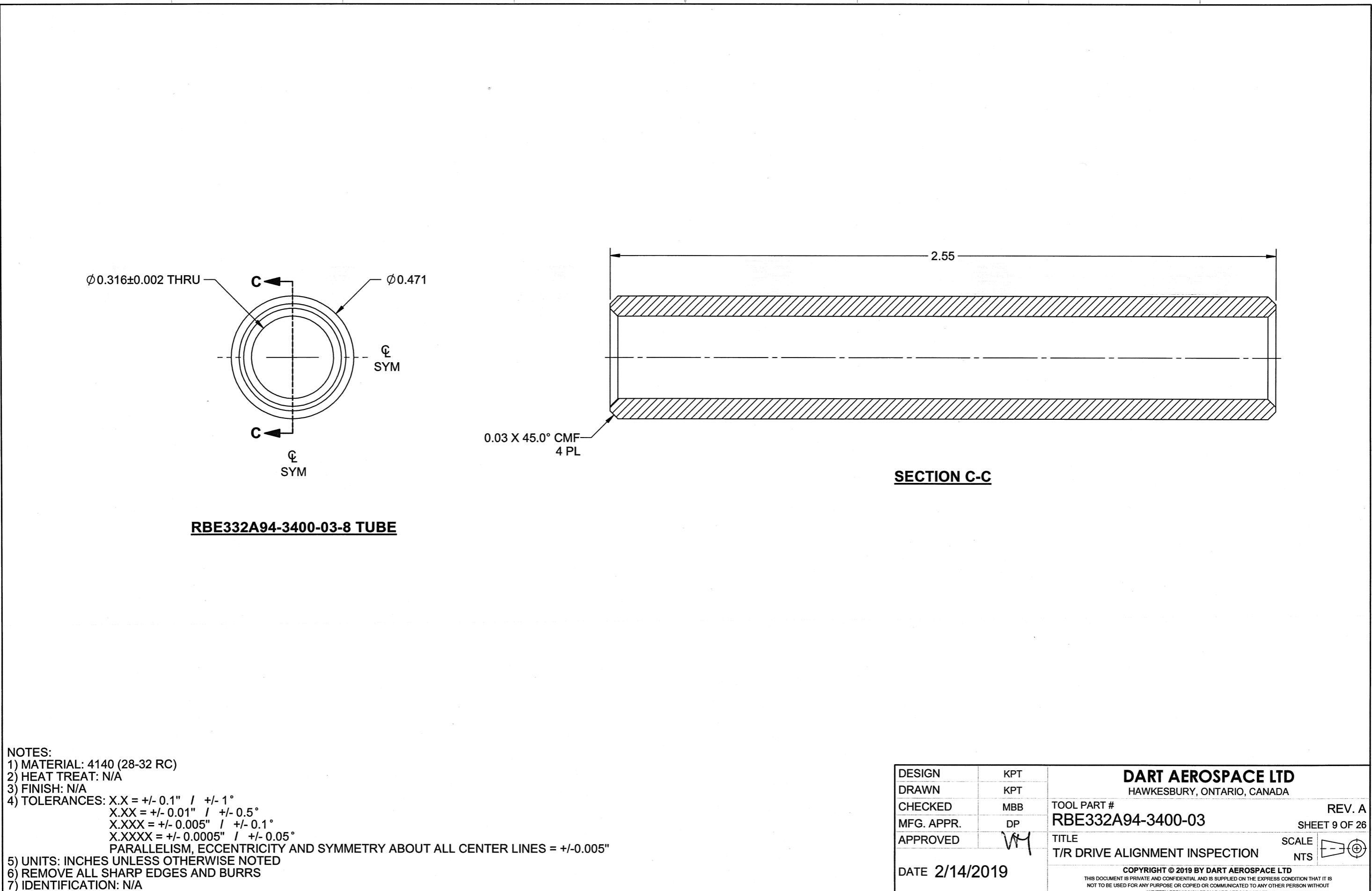
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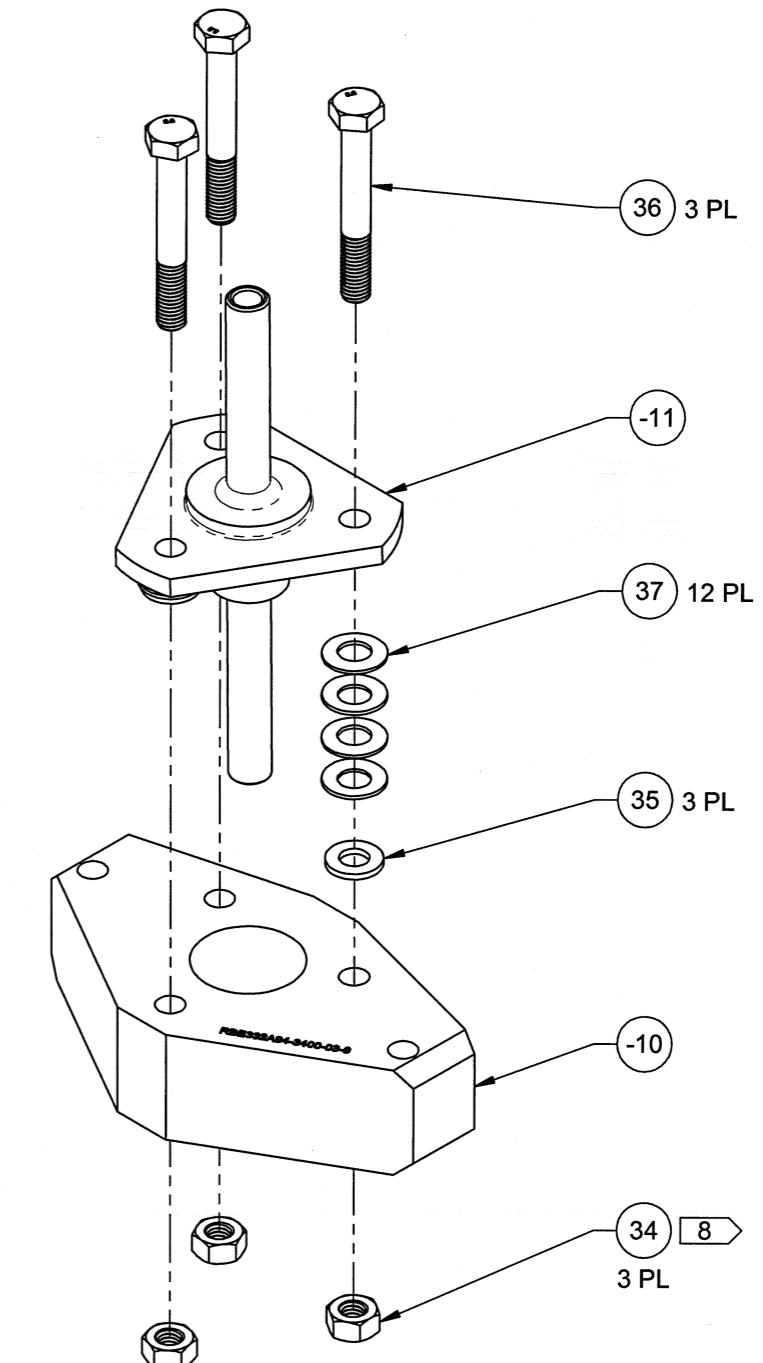
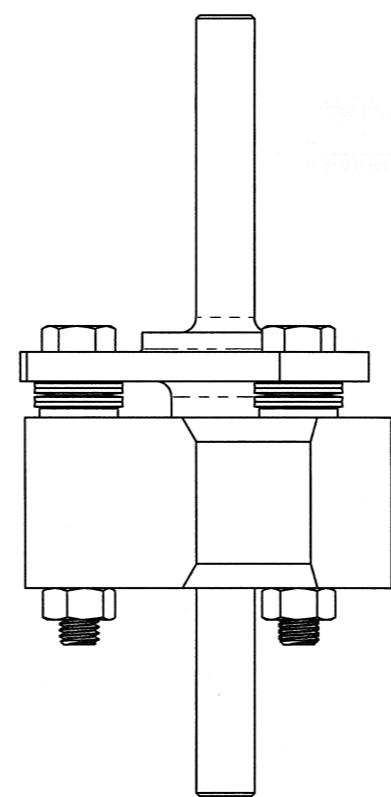
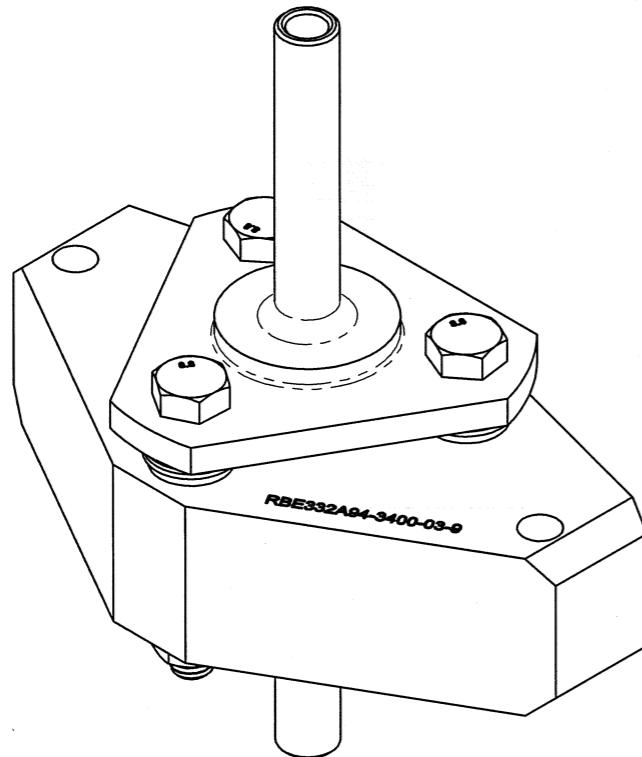
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DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	WY	REV. A SHEET 9 OF 26
		TITLE T/R DRIVE ALIGNMENT INSPECTION
		SCALE NTS
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DATE 2/14/2019

ITEM #	QTY	PART #	PART TITLE
-10	1	RBE332A94-3400-03-10	BLOCK
-11	1	RBE332A94-3400-03-11	SUPPORT
34	3	McMaster#90591A161 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M8 X 1.25 mm X 6.5 mm HT.
35	3	McMaster#91166A270 OR EQUIV.	ZINC PLATED STEEL WASHER 8.4 mm ID. X 16 mm OD. X 1.4 mm-1.8 mm THK.
36	3	McMaster#91280A550 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M8 X 1.25 mm X 60 mm LG.
37	12	McMaster#96445K241 OR EQUIV.	STEEL BELLEVILLE DISC SPRING 9.2 mm ID. X 18 mm OD. X 1 mm THK.



RBE332A94-3400-03-9 SIGHT SUPPORT

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 34 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	REV. A
APPROVED	VW	RBE332A94-3400-03	SHEET 10 OF 26
DATE 2/14/2019		TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
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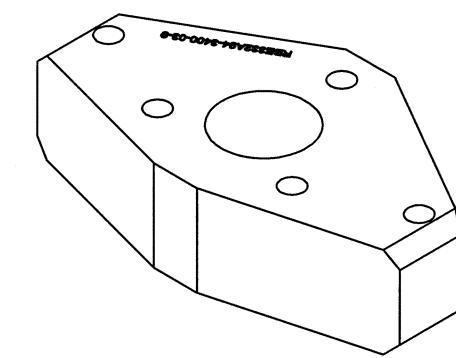
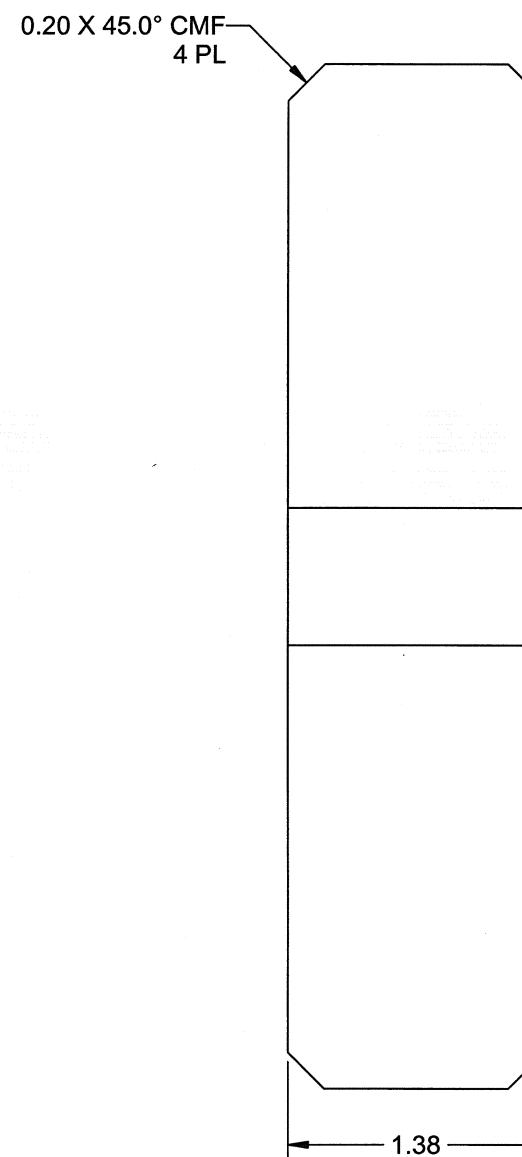
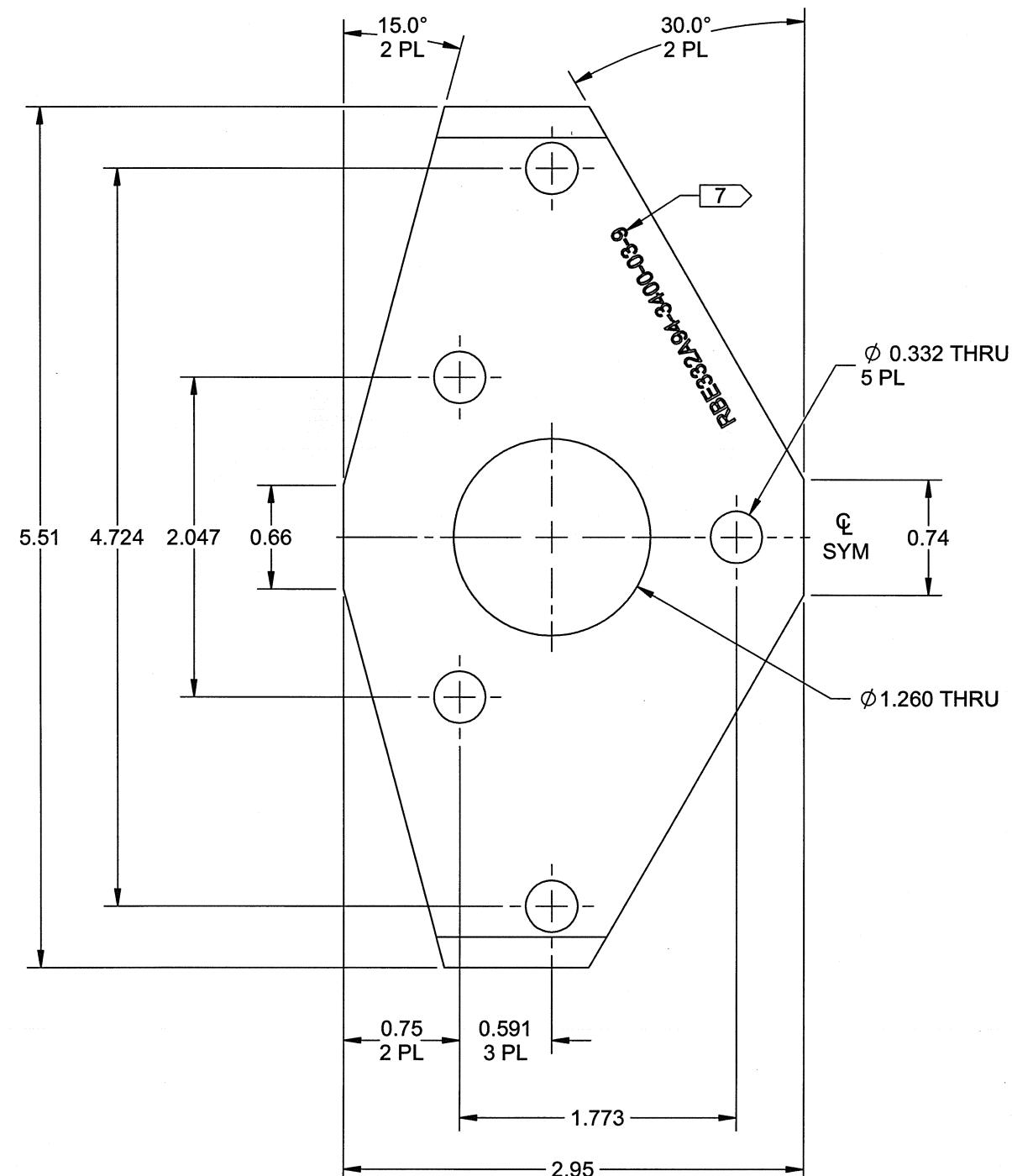
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RBE332A94-3400-03-10 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB		
MFG. APPR.	DP	TOOL PART #	
APPROVED	WP	RBE332A94-3400-03	
DATE 2/14/2019		REV. A	SHEET 11 OF 26
TITLE		T/R DRIVE ALIGNMENT INSPECTION	
SCALE		NTS	

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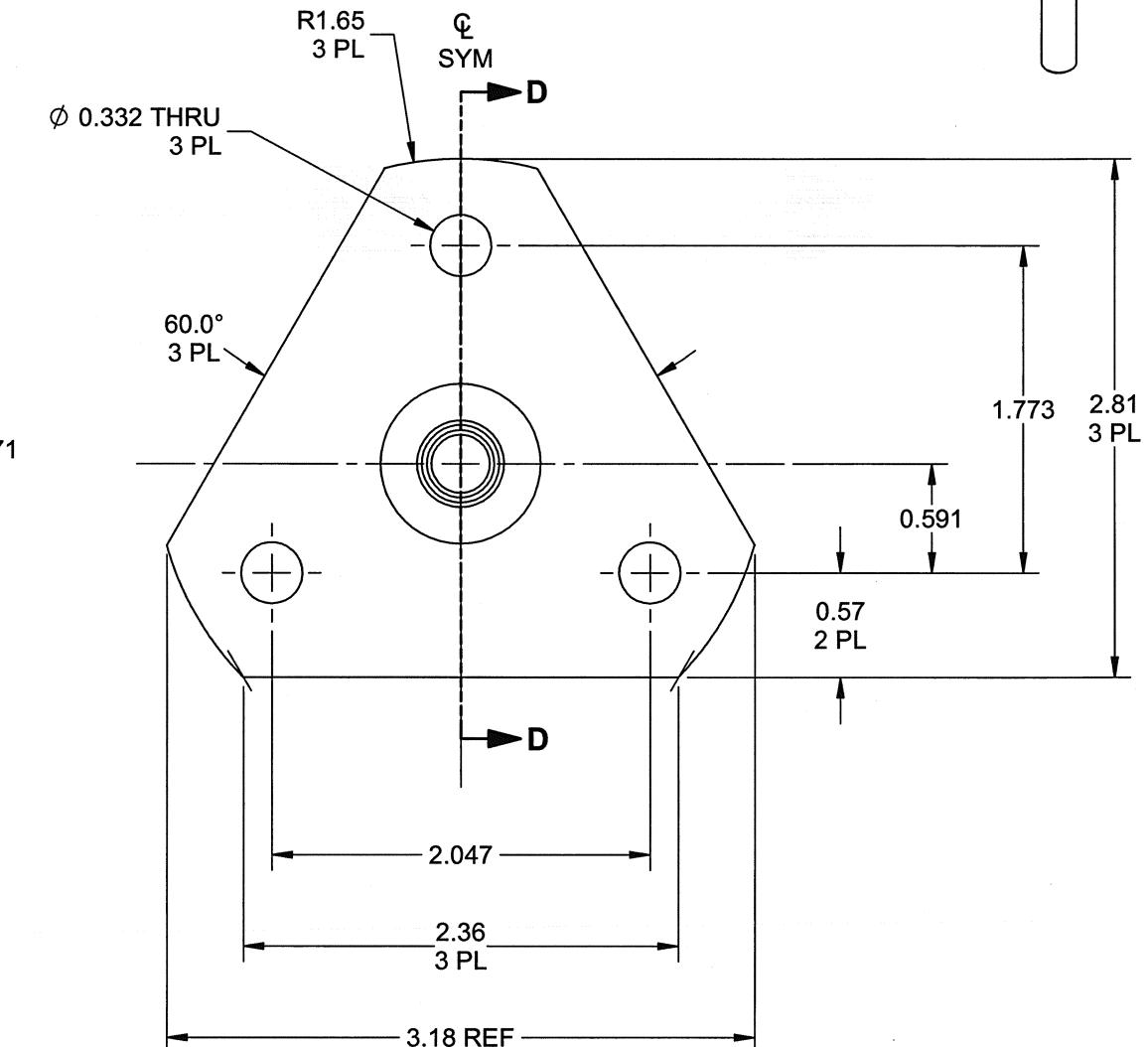
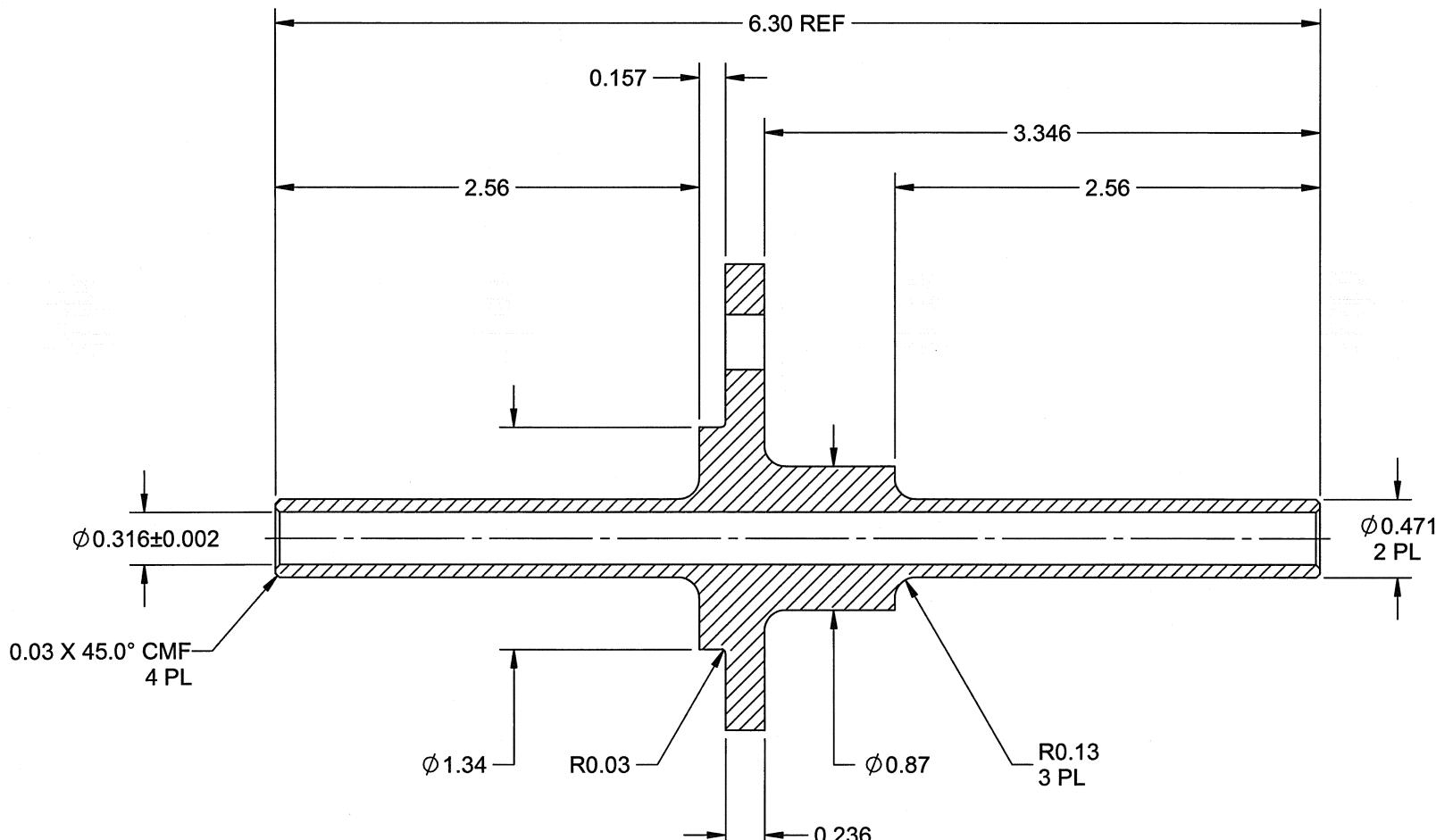
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**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	VJ	REV. A SHEET 12 OF 26
		TITLE T/R DRIVE ALIGNMENT INSPECTION
		SCALE NTS
		DATE 2/14/2019
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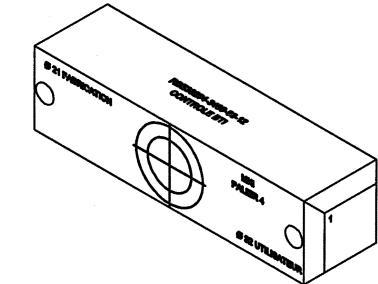
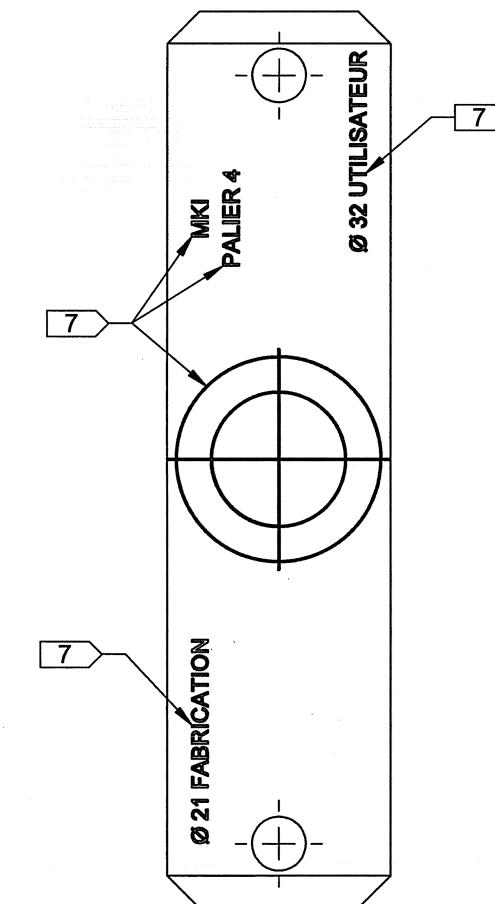
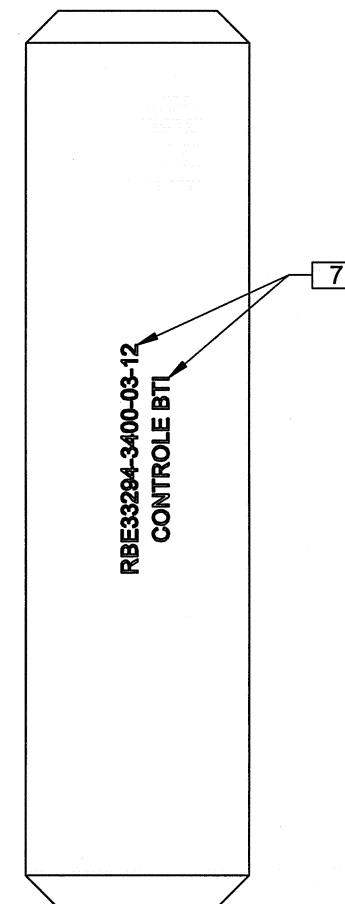
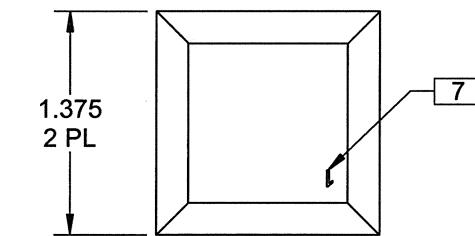
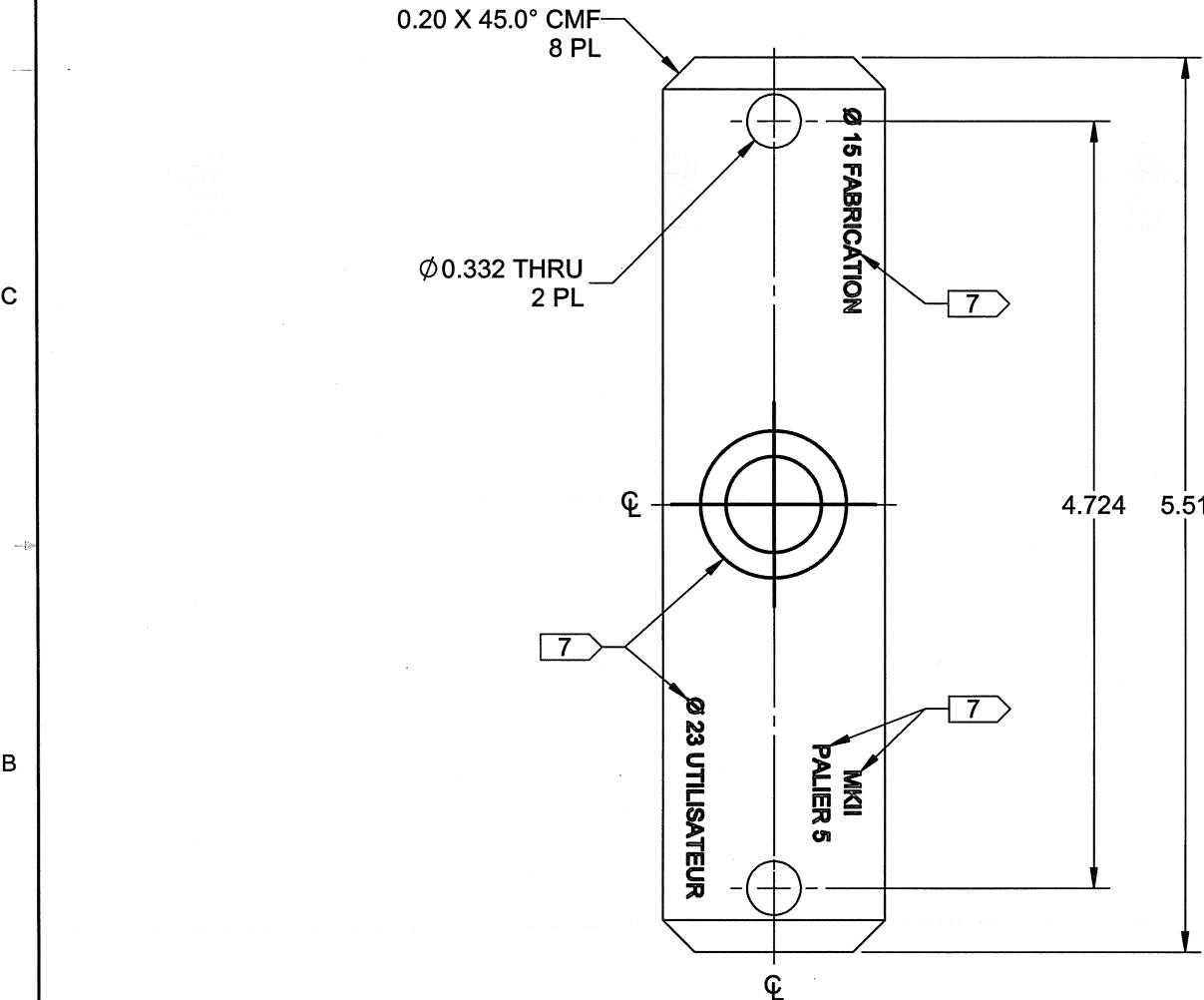
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RBE332A94-3400-03-12 TARGET BLOCK 4 & 5

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN DRAWN	KPT	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	MBB	REV. A	
APPROVED	DP	TOOL PART # RBE332A94-3400-03	
		SHEET 13 OF 26	
		TITLE T/R DRIVE ALIGNMENT INSPECTION	
		SCALE NTS	
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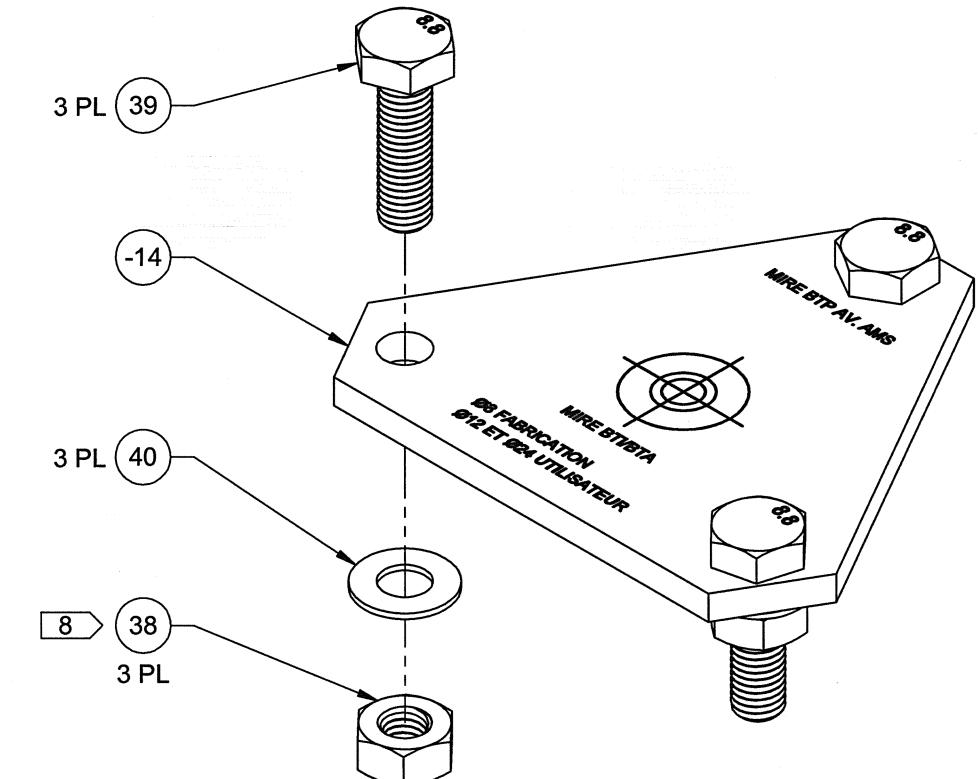
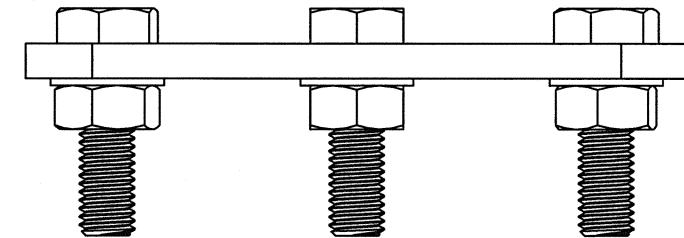
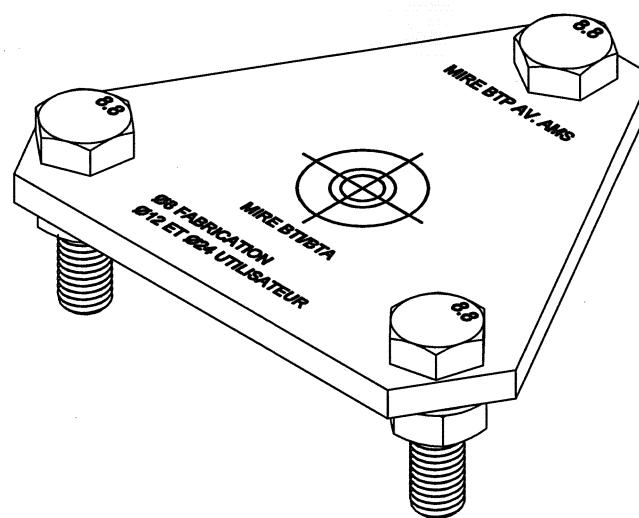
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ITEM #	QTY	PART #	PART TITLE
-14	1	RBE332A94-3400-03-14	BASE
38	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
39	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
40	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.

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RBE332A94-3400-03-13 TARGET MGB / IGB / TGB

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NOTES:

- 1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH:

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) INSTALL ITEM 38 HAND TIGHT

9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	
MFG. APPR.	DP	REV. A	
APPROVED	WJ	RBE332A94-3400-03	
DATE 2/14/2019		SHEET 14 OF 26	
TITLE		SCALE	
T/R DRIVE ALIGNMENT INSPECTION		NTS	
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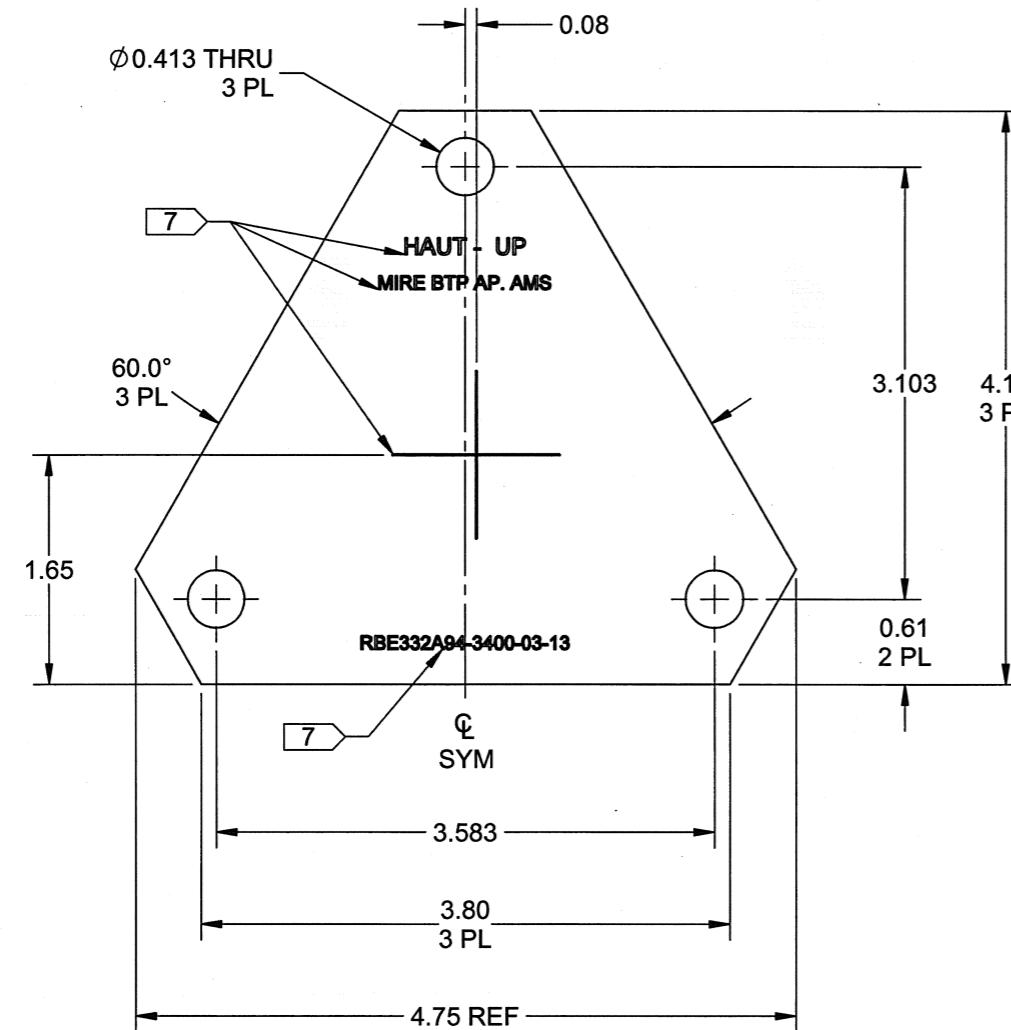
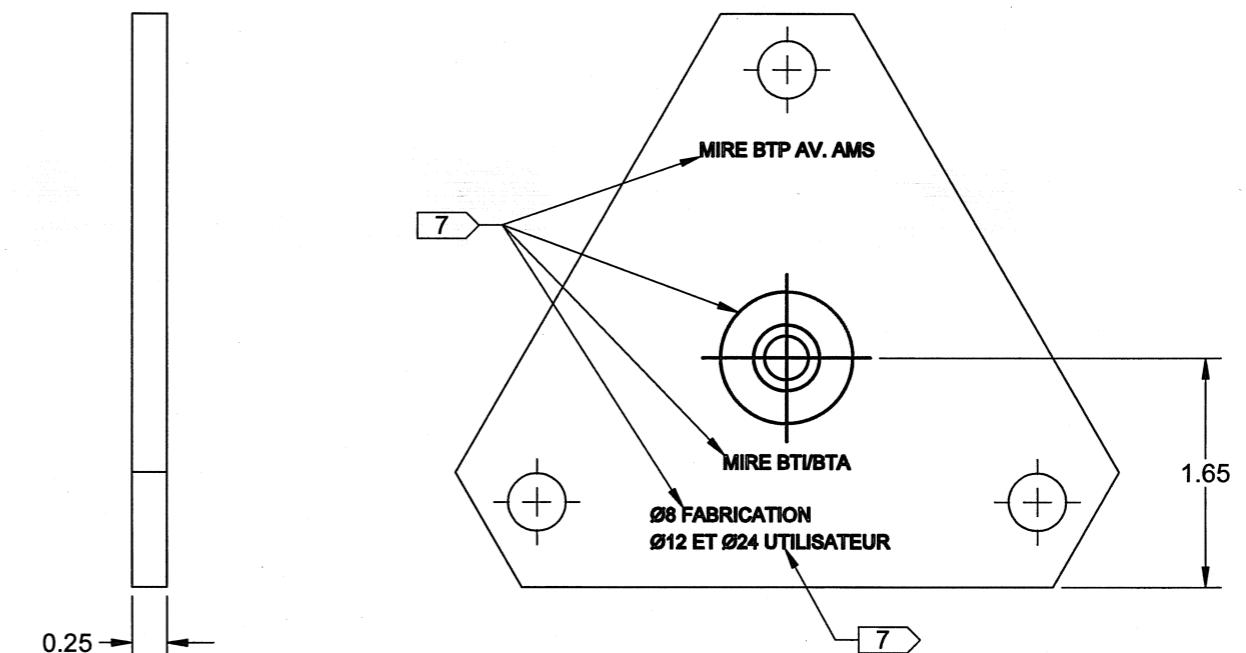
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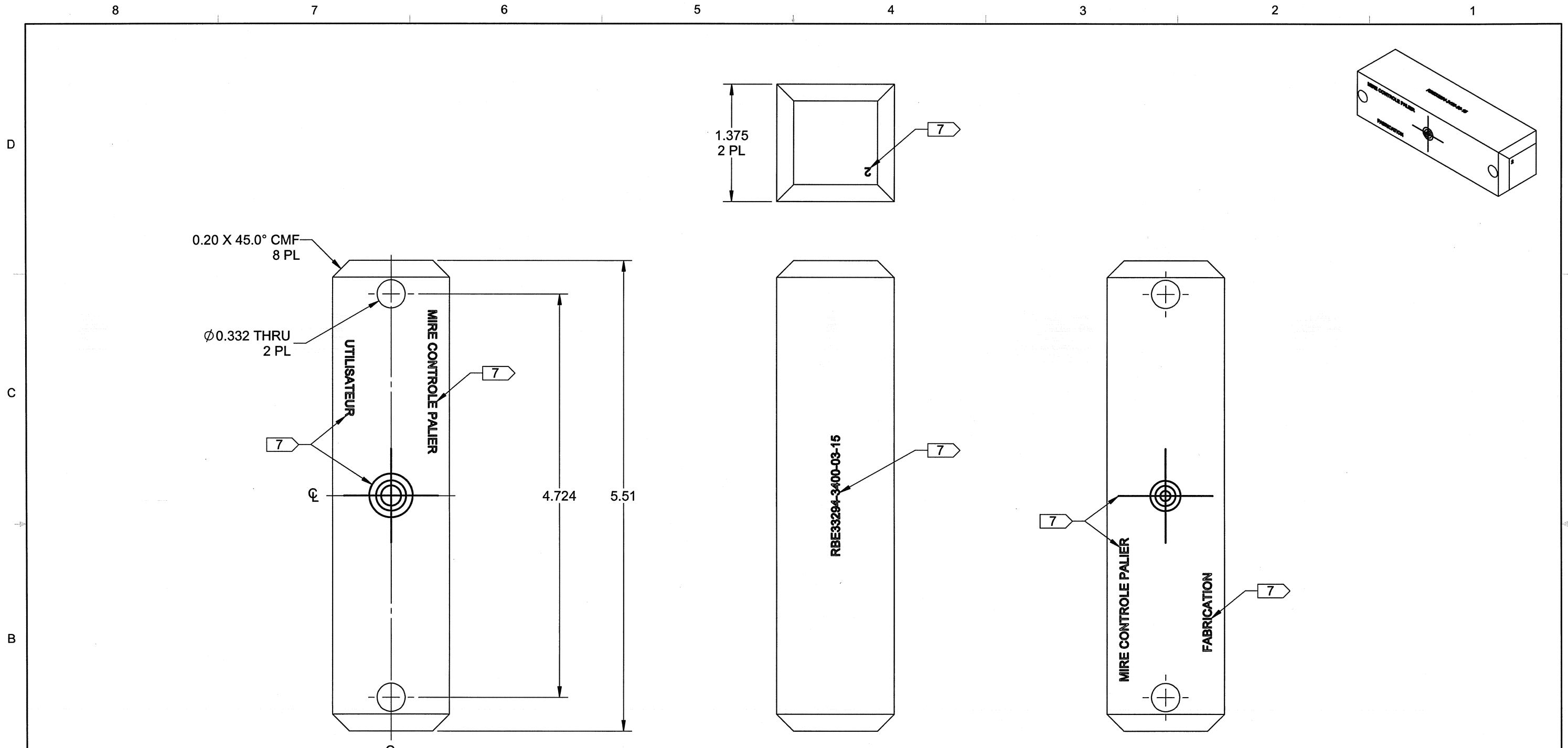
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**RBE332A94-3400-03-14 BASE****NOTES:**

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	WJ	REV. A SHEET 15 OF 26
		TITLE T/R DRIVE ALIGNMENT INSPECTION
		SCALE NTS
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		DATE 2/14/2019



RBE332A94-3400-03-15 TARGET BLOCK 2 TO 6

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	REV. A
MFG. APPR.	DP	TOOL PART #
APPROVED	VH	RBE332A94-3400-03
DATE 2/14/2019		SHEET 16 OF 26
TITLE		T/R DRIVE ALIGNMENT INSPECTION
SCALE		NTS
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ITEM #	QTY	PART #	PART TITLE
-17	1	RBE332A94-3400-03-17	BASE
-18	3	RBE332A94-3400-03-18	STANOFF
41	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
42	3	McMaster#91280A640 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.50 mm X 45 mm LG.
43	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.

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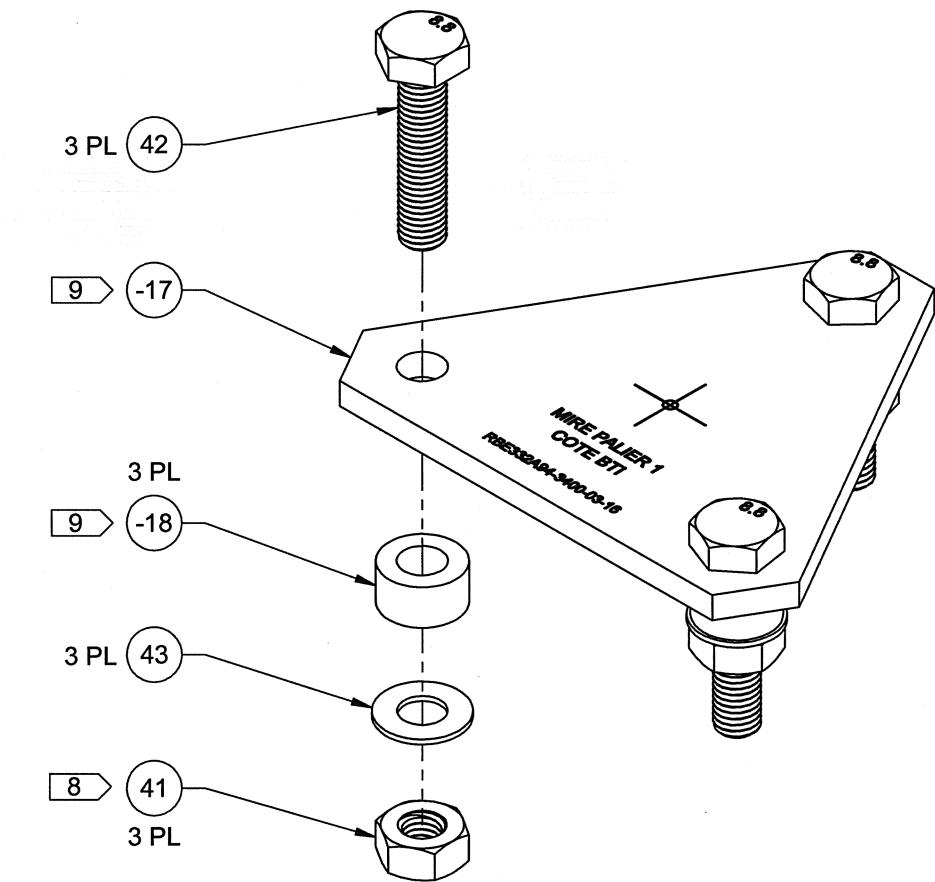
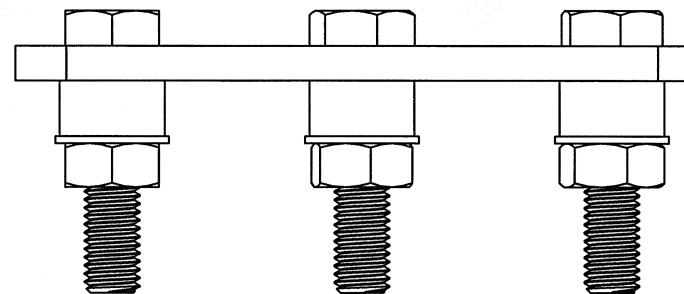
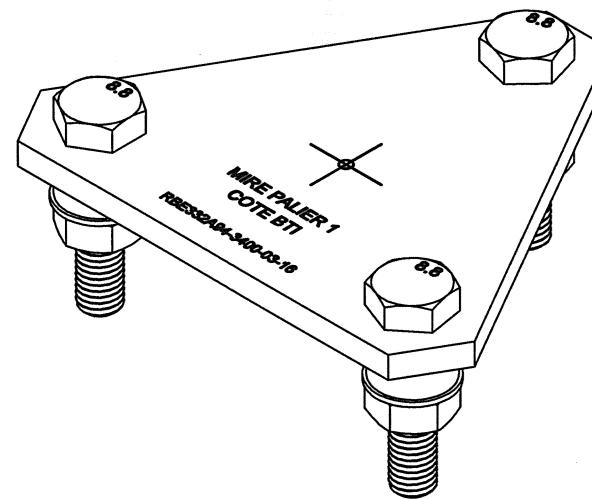
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RBE332A94-3400-03-16 TARGET BLOCK 1 FABRICATION

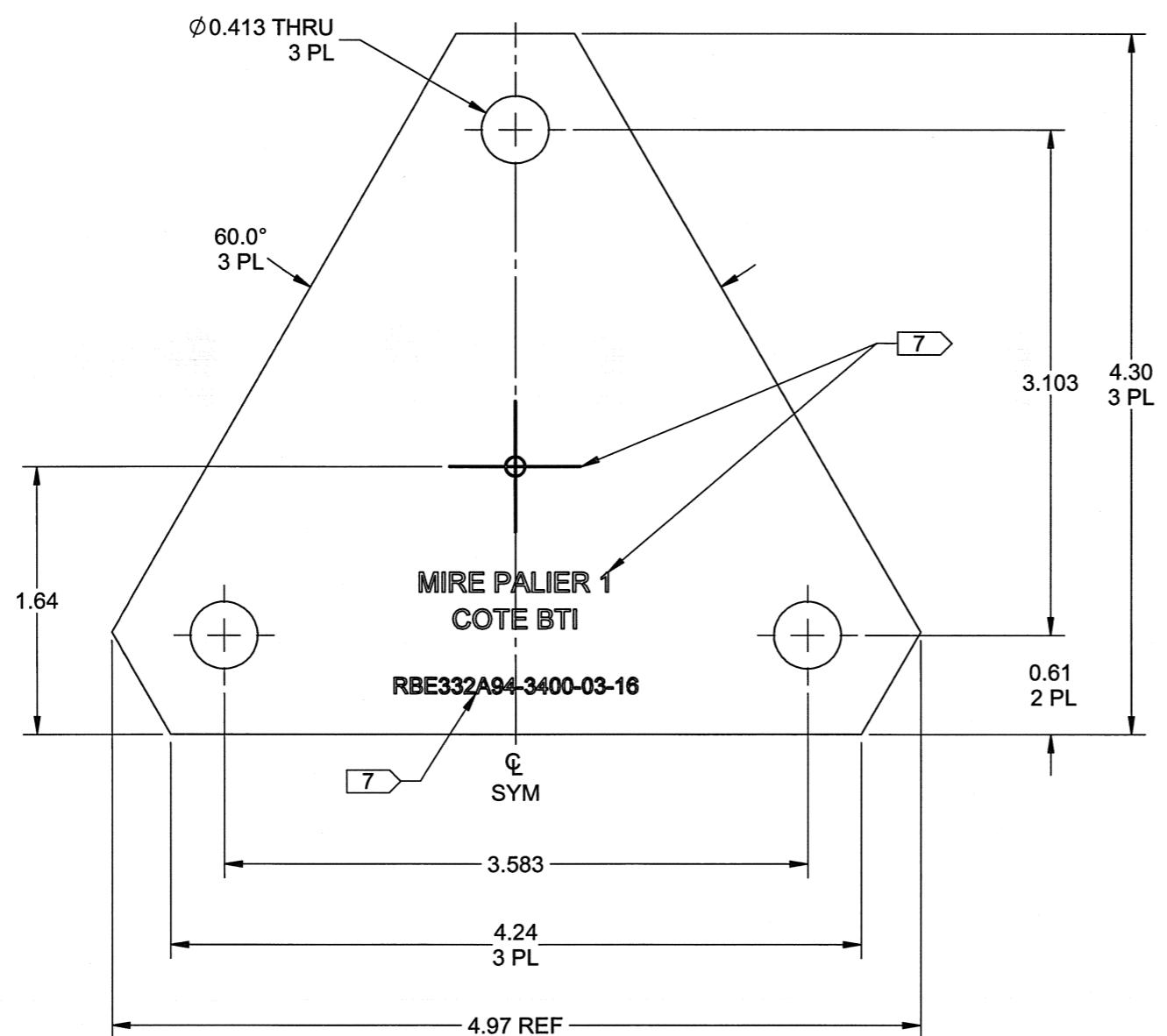
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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 41 HAND TIGHT
- 9) ALIGN ITEM -17 AND -18 THEN APPLY LOCTITE 495 BETWEEN THE SURFACES, AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN DRAWN	KPT KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MBB	TOOL PART #
MFG. APPR.	DP	RBE332A94-3400-03
APPROVED	WY	REV. A
TITLE T/R DRIVE ALIGNMENT INSPECTION		SHEET 17 OF 26
DATE 2/14/2019		SCALES NTS

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RBE332A94-3400-03-17 BASE

NOTES:
1) MATERIAL: McMaster#8574K281 OR EQUIV.
2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES

X.XX = +/- 0.01" / +/-

X.XXX = +/- 0.005" / +/- 0.005"

$\times \text{XXXX} = \pm/-0.0005''$ / $\pm/-0.$

PARALLELISM ECCENTRICITY

PARALLELISM, ECCENTRICITY
ES UNLESS OTHERWISE NOTED

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	
MFG. APPR.	DP	REV. A	
APPROVED	VJ	RBE332A94-3400-03	
		SHEET 18 OF 26	
		TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
DATE 2/14/2019			
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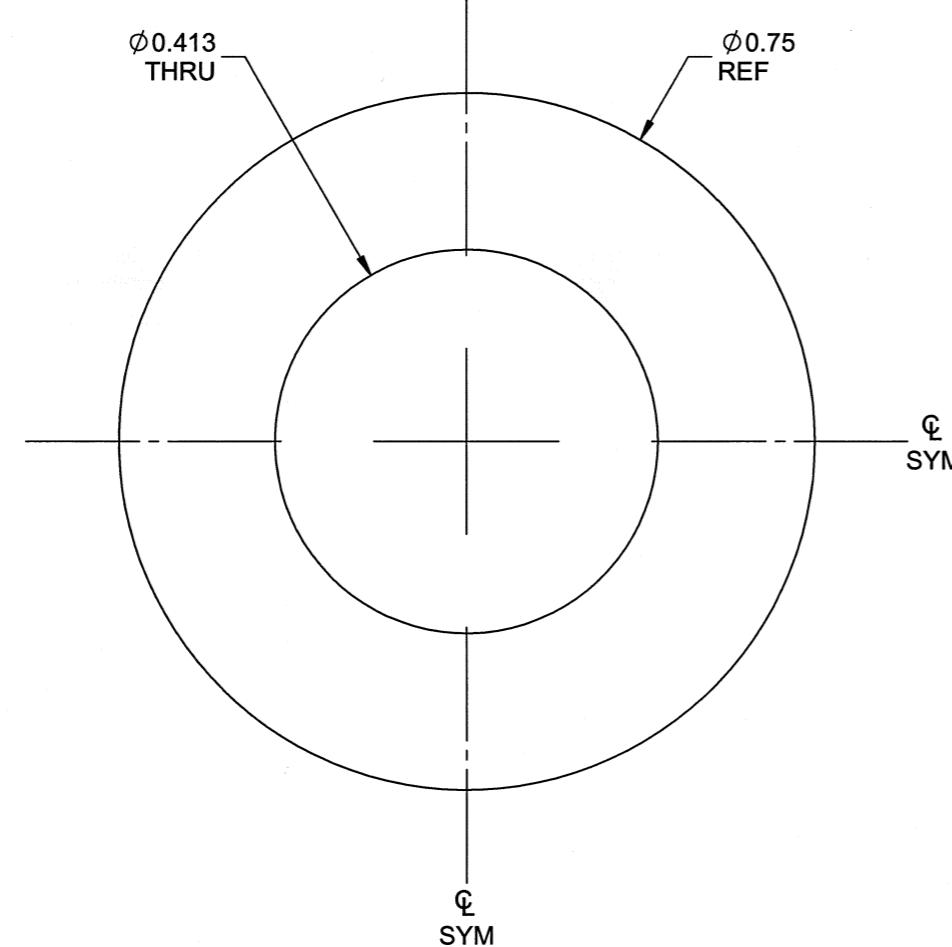
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RBE332A94-3400-03-18 STANDOFF

NOTES:

- 1) MATERIAL: McMaster#8571K15 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD			
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MBB				
MFG. APPR.	DP				
APPROVED	WY				
TOOL PART #		RBE332A94-3400-03			
REV. A		SHEET 19 OF 26			
TITLE		T/R DRIVE ALIGNMENT INSPECTION			
SCALE		NTS			
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DATE 2/14/2019

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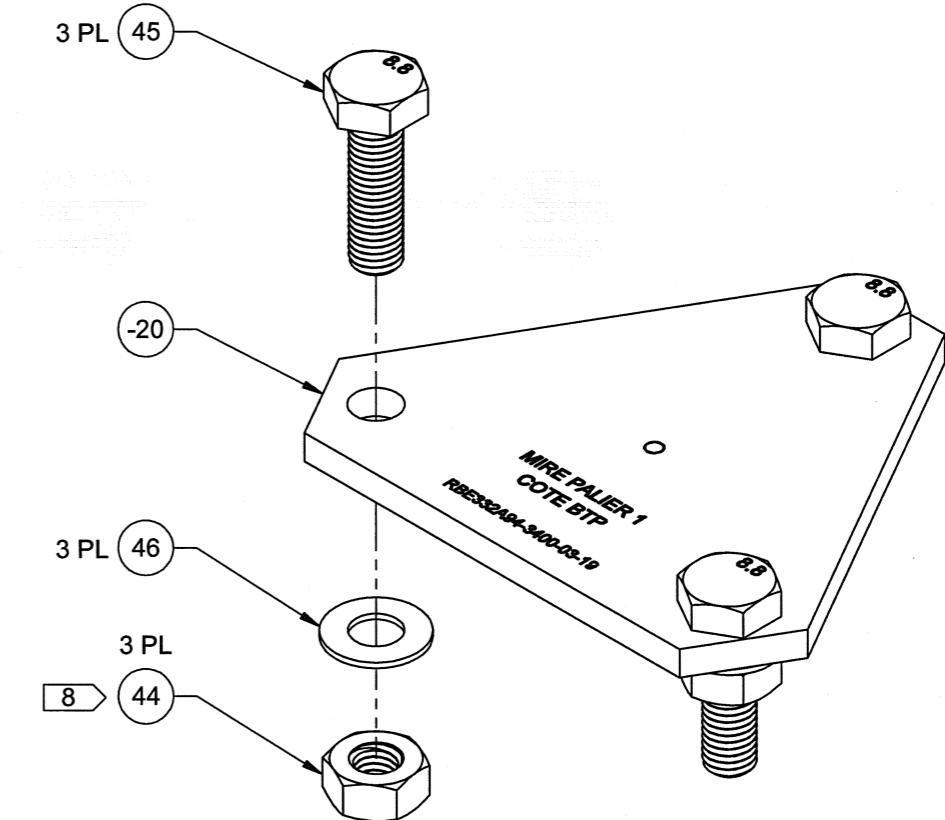
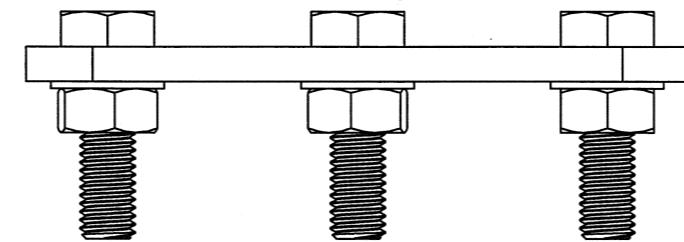
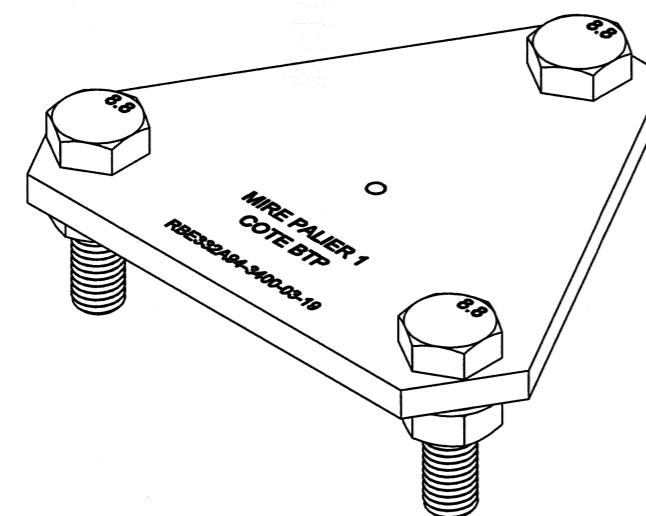
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ITEM #	QTY	PART #	PART TITLE
-20	1	RBE332A94-3400-03-20	BASE
44	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
45	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
46	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.

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RBE332A94-3400-03-19 TARGET BLOCK 1 FABRICATION

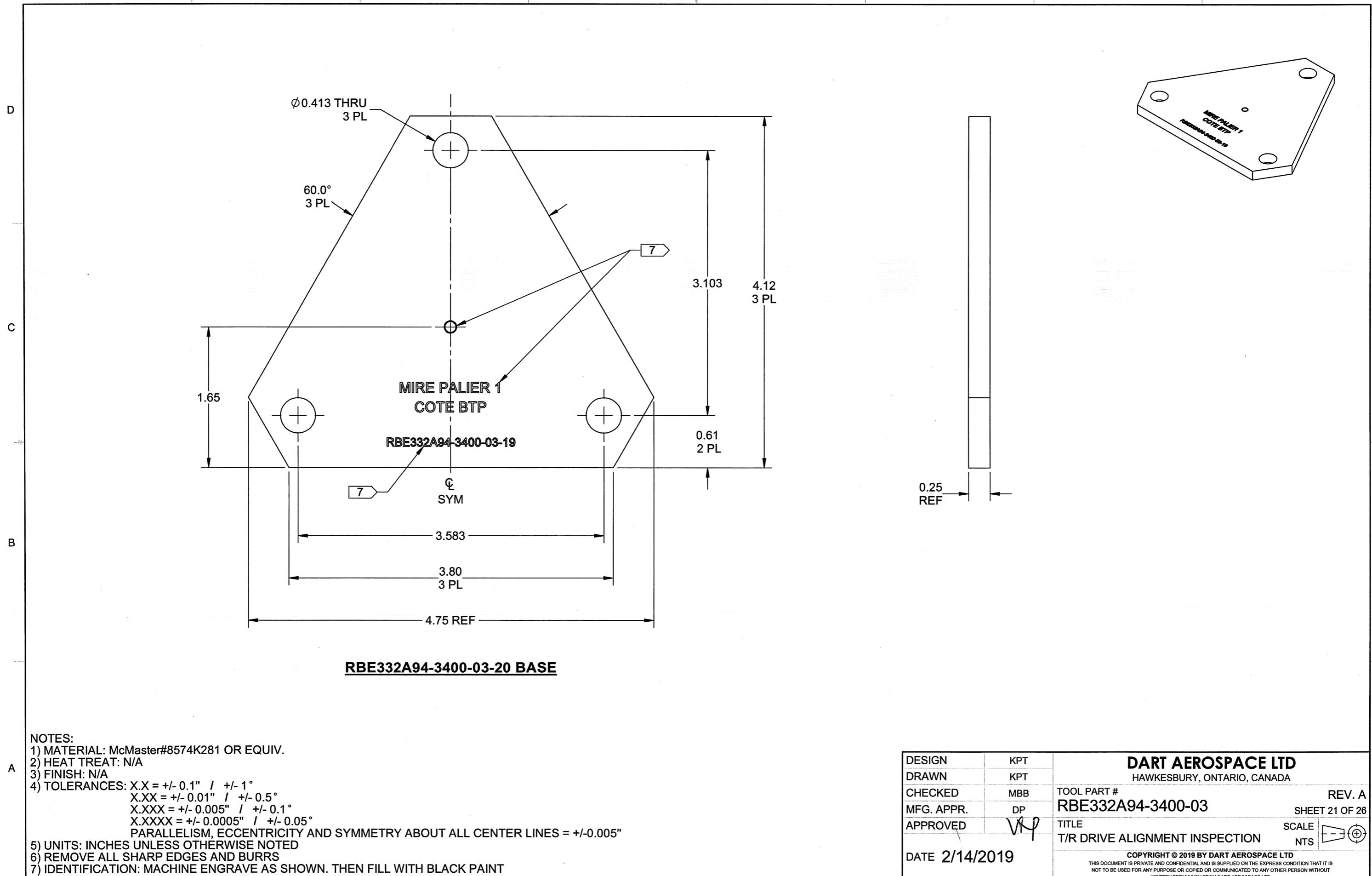
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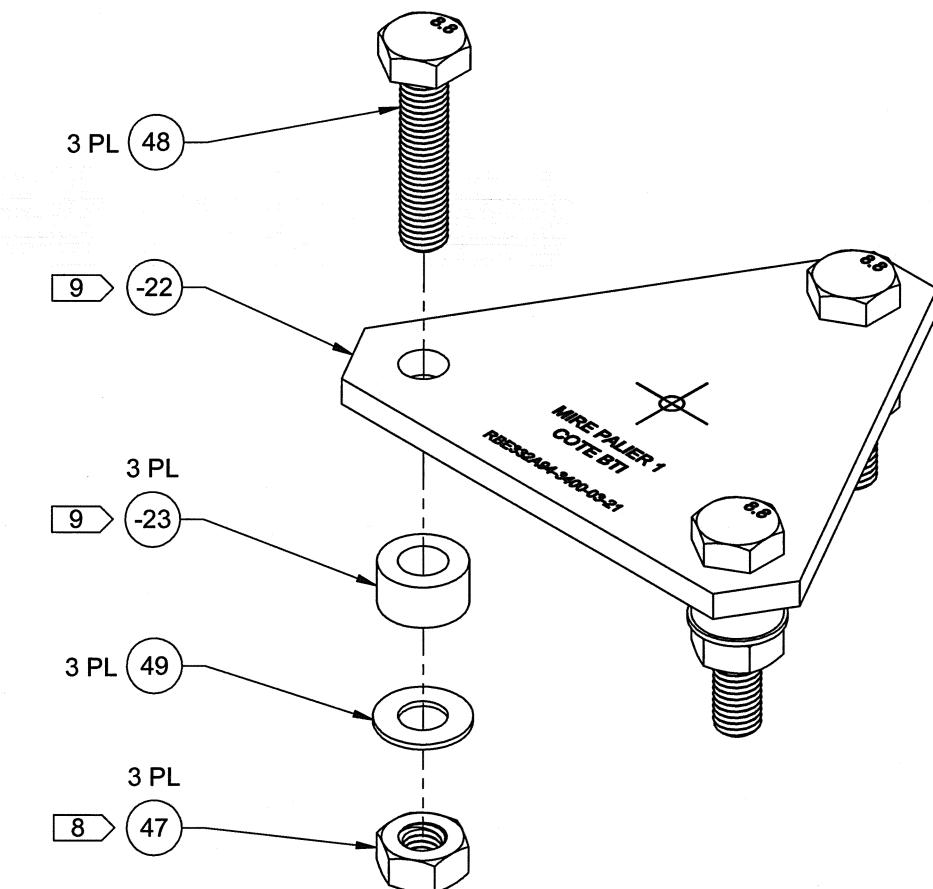
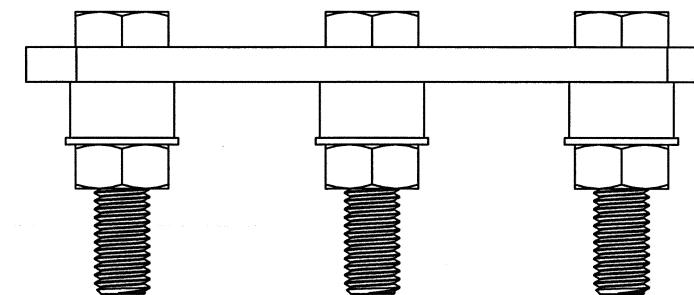
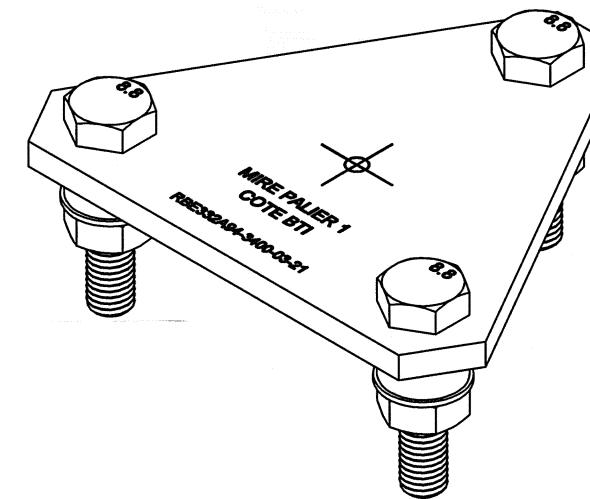
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 44 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN DRAWN	KPT	DART AEROSPACE LTD	
CHECKED	MBB	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DP	TOOL PART #	REV. A
APPROVED	WY	RBE332A94-3400-03	SHEET 20 OF 26
DATE 2/14/2019		TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	NTS
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ITEM #	QTY	PART #	PART TITLE
-22	1	RBE332A94-3400-03-22	BASE
-23	3	RBE332A94-3400-03-23	STANDOFF
47	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
48	3	McMaster#91280A640 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.50 mm X 45 mm LG.
49	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.



RBE332A94-3400-03-21 TARGET BLOCK 1 USER

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 47 HAND TIGHT
- 9) ALIGN ITEM -22 AND -23 THEN APPLY LOCTITE 495 BETWEEN THE SURFACES, AND REMOVE EXCESS
- 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	REV. A	
MFG. APPR.	DP	TOOL PART #	
APPROVED	VJ	RBE332A94-3400-03	
DATE 2/14/2019		TITLE	
		T/R DRIVE ALIGNMENT INSPECTION	
		SCALE	NTS
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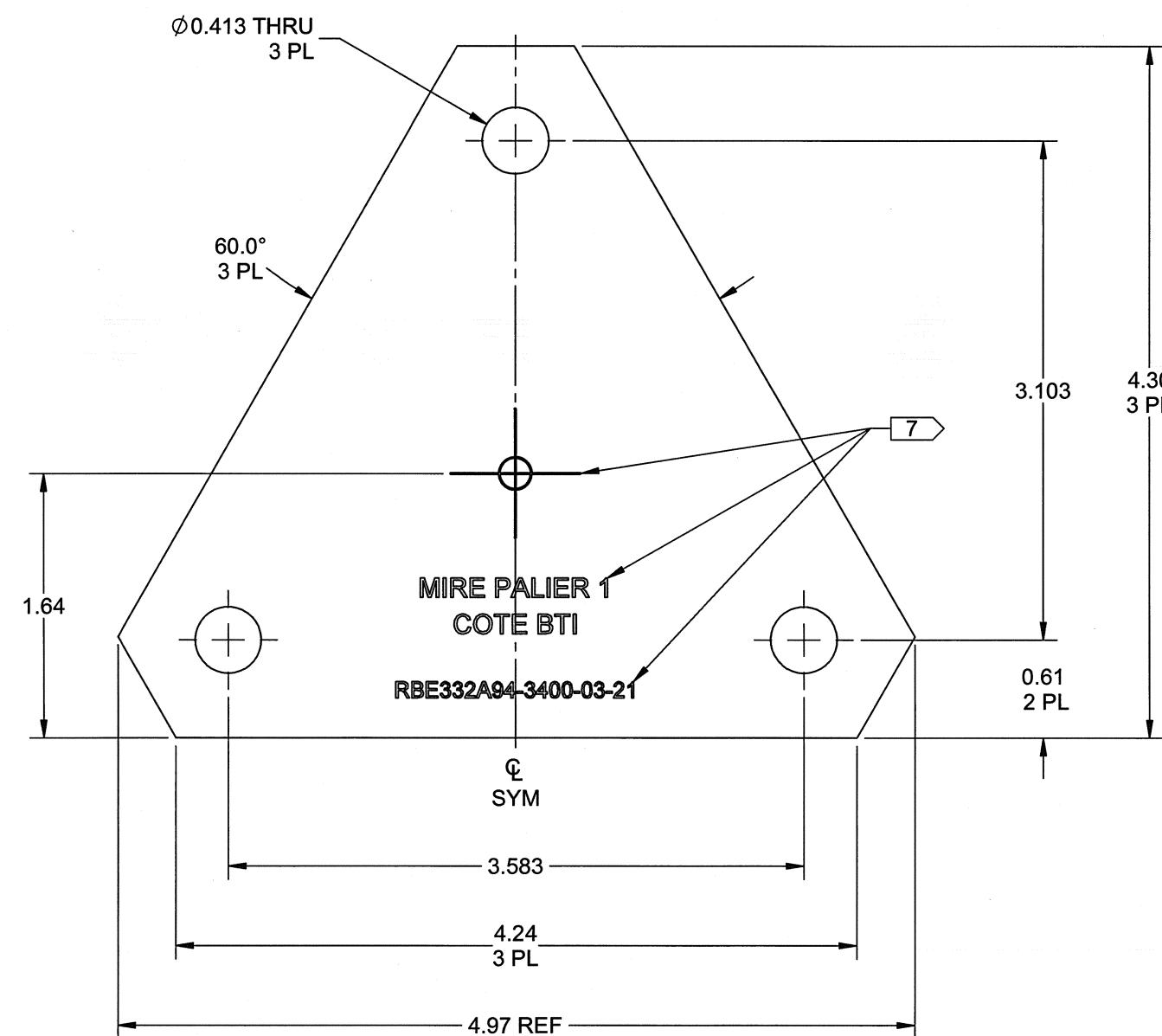
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RBE332A94-3400-03-22 BASE

NOTES:

- 1) MATERIAL: McMaster#8574K281 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN	KPT	DART AEROSPACE LTD			
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MBB	REV. A			
MFG. APPR.	DP	TOOL PART # RBE332A94-3400-03			
APPROVED	<i>[Signature]</i>	SHEET 23 OF 26			
TITLE		T/R DRIVE ALIGNMENT INSPECTION			
DATE 2/14/2019		SCALE NTS			
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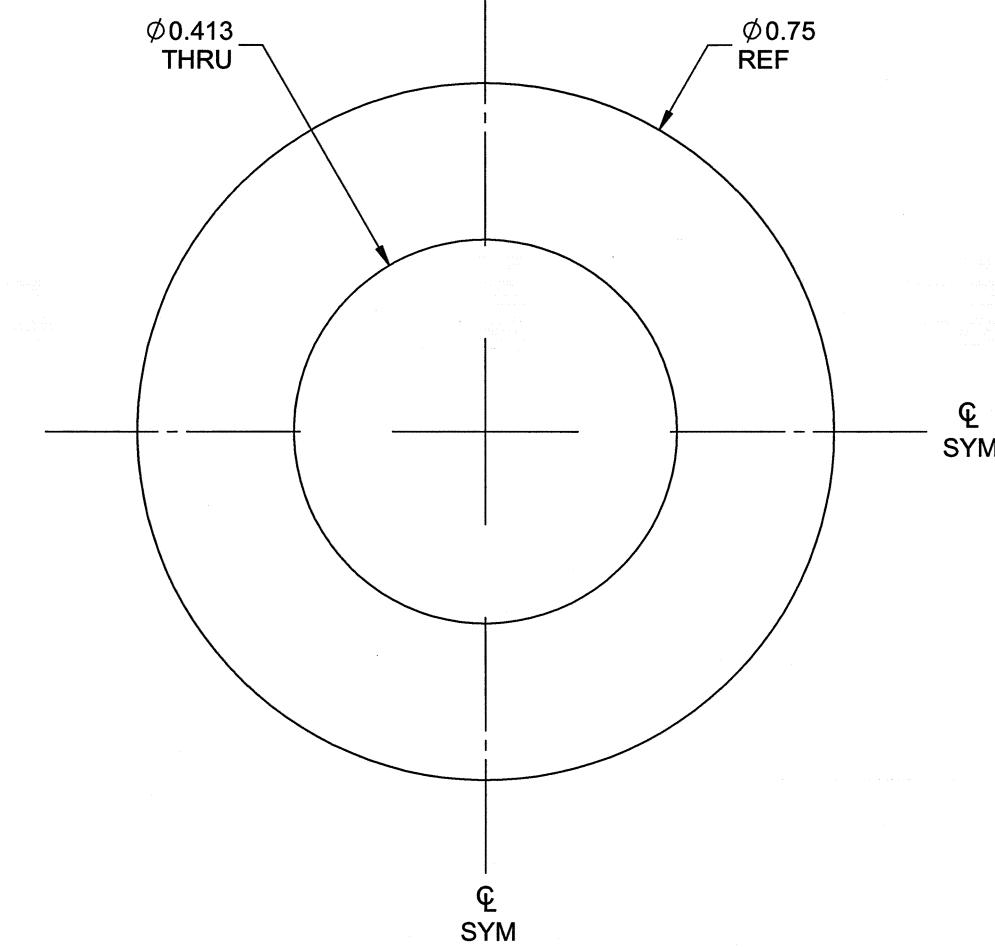
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RBE332A94-3400-03-23 STANDOFF

NOTES:

- 1) MATERIAL: McMaster#8571K15 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD			
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MBB	TOOL PART #			
MFG. APPR.	DP	RBE332A94-3400-03			
APPROVED	VTP	REV. A			
TITLE		SHEET 24 OF 26			
T/R DRIVE ALIGNMENT INSPECTION		SCALE			
DATE 2/14/2019		NTS			
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ITEM #	QTY	PART #	PART TITLE
-25	1	RBE332A94-3400-03-25	BASE
50	3	McMaster#90591A171 OR EQUIV.	ZINC PLATED CLASS 8 STEEL HEX NUT M10 X 1.5 mm X 8 mm HT.
51	3	McMaster#91280A636 OR EQUIV.	ZINC PLATED CLASS 8.8 STEEL HEX HEAD SCREW M10 X 1.5 mm X 35 mm LG.
52	3	McMaster#98023A031 OR EQUIV.	YELLOW ZINC PLATED GRADE 8 STEEL WASHER 0.406" ID. X 0.812" OD. X 0.051"-0.080" THK.

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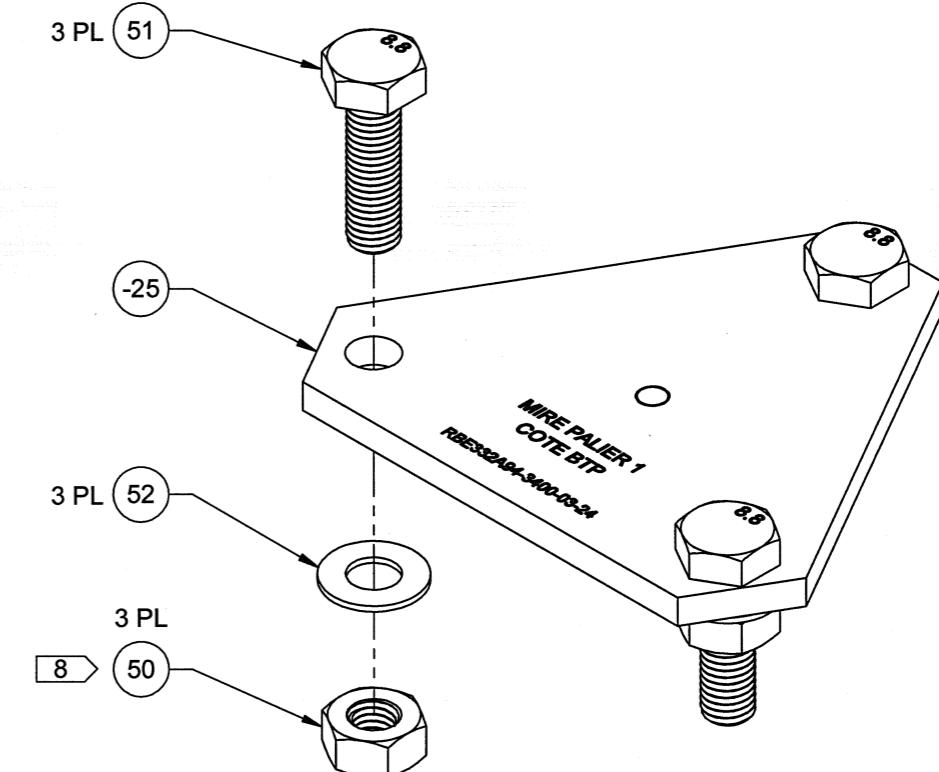
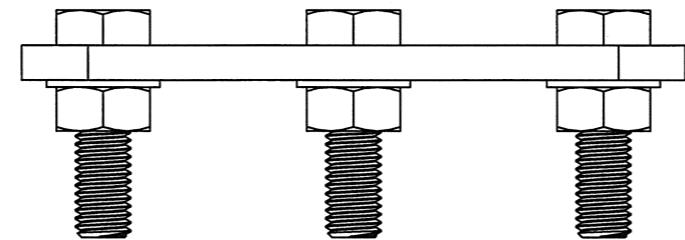
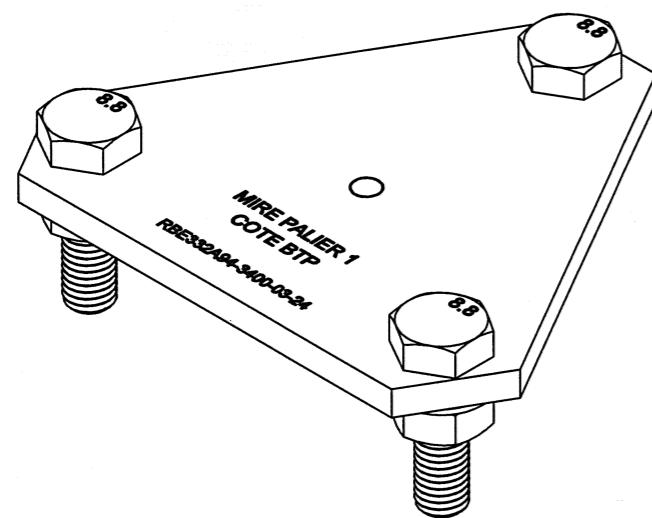
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RBE332A94-3400-03-24 TARGET BLOCK 1 USER

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM 50 HAND TIGHT
- 9) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

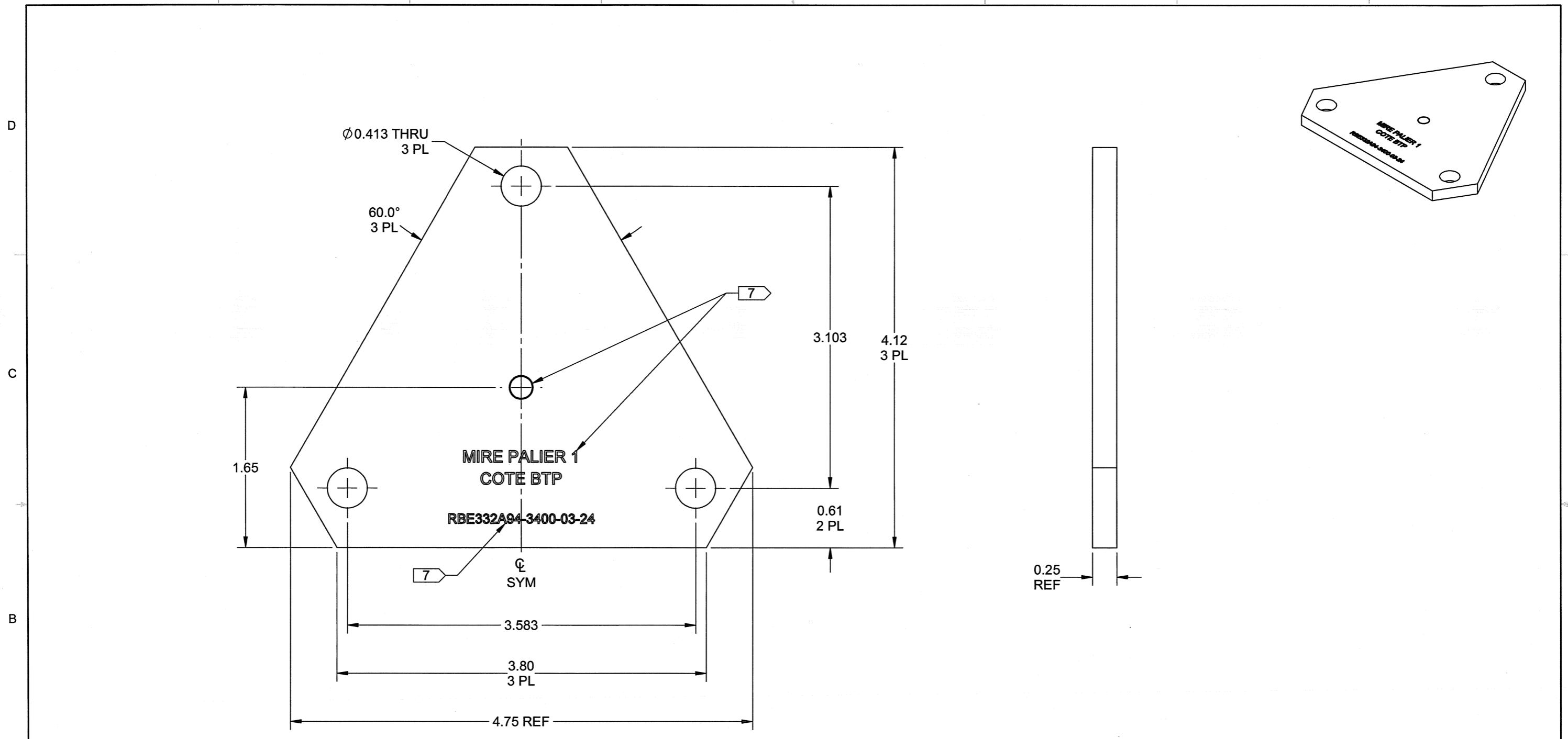
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	REV. A	
MFG. APPR.	DP	TOOL PART #	
APPROVED	VJ	RBE332A94-3400-03	
DATE 2/14/2019		TITLE	
		T/R DRIVE ALIGNMENT INSPECTION	
		SCALE	
		NTS	

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NOTES:

- 1) MATERIAL: McMaster#8574K281 OR EQUIV.
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN. THEN FILL WITH BLACK PAINT

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBE332A94-3400-03	SHEET 26 OF 26
APPROVED	<i>[Signature]</i>	TITLE	SCALE
		T/R DRIVE ALIGNMENT INSPECTION	
		DATE 2/14/2019	NTS

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